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Okahisa et al.

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(54) **LENS, LIGHT EMITTING DEVICE AND METHOD OF MANUFACTURING THE LENS AND THE LIGHT EMITTING DEVICE**

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H01L 21/56 (2006.01)
H01L 33/56 (2010.01)
B29K 101/10 (2006.01)
H01L 33/54 (2010.01)

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(58) **Field of Classification Search**
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See application file for complete search history.

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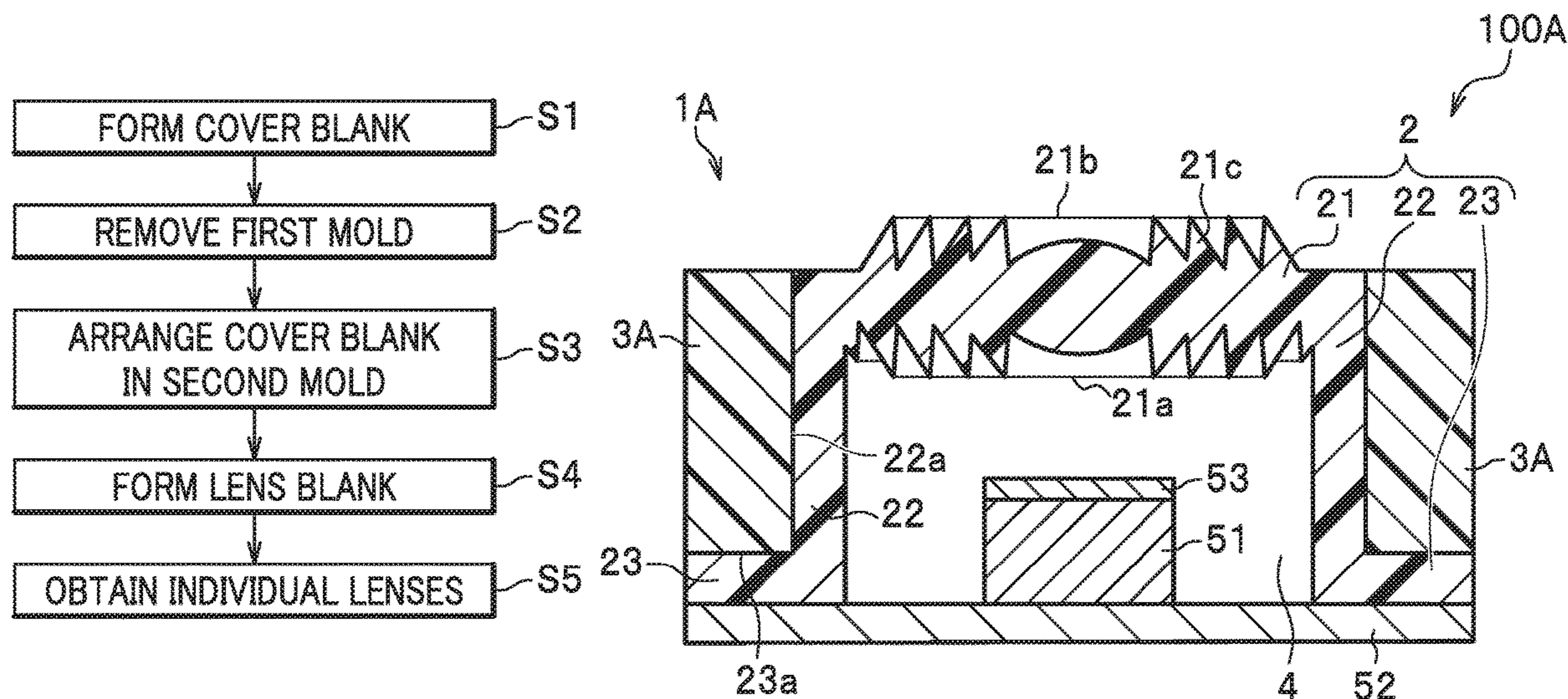
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(74) *Attorney, Agent, or Firm* — Mori & Ward, LLP

(57) **ABSTRACT**
A lens includes a cover part and a light-shielding part. The cover part includes a lens part, a connection part, and a flange part which are formed of a thermosetting first resin and continuous to one another. The light-shielding part covers an outer lateral side of the connection part and is formed of a second resin having a greater light-absorptance or a greater light-reflectance than the first resin.

9 Claims, 12 Drawing Sheets



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FIG. 1

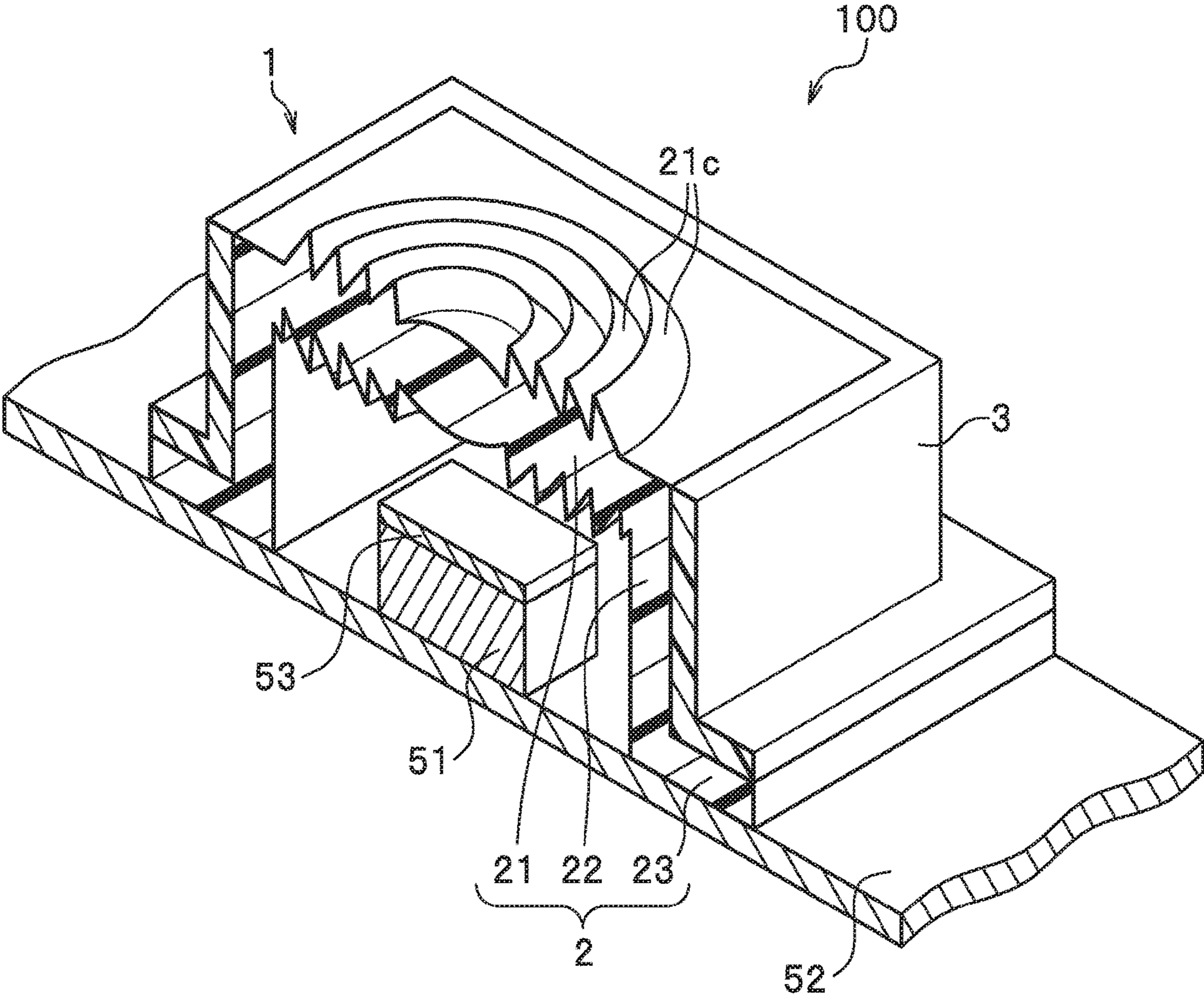


FIG. 2

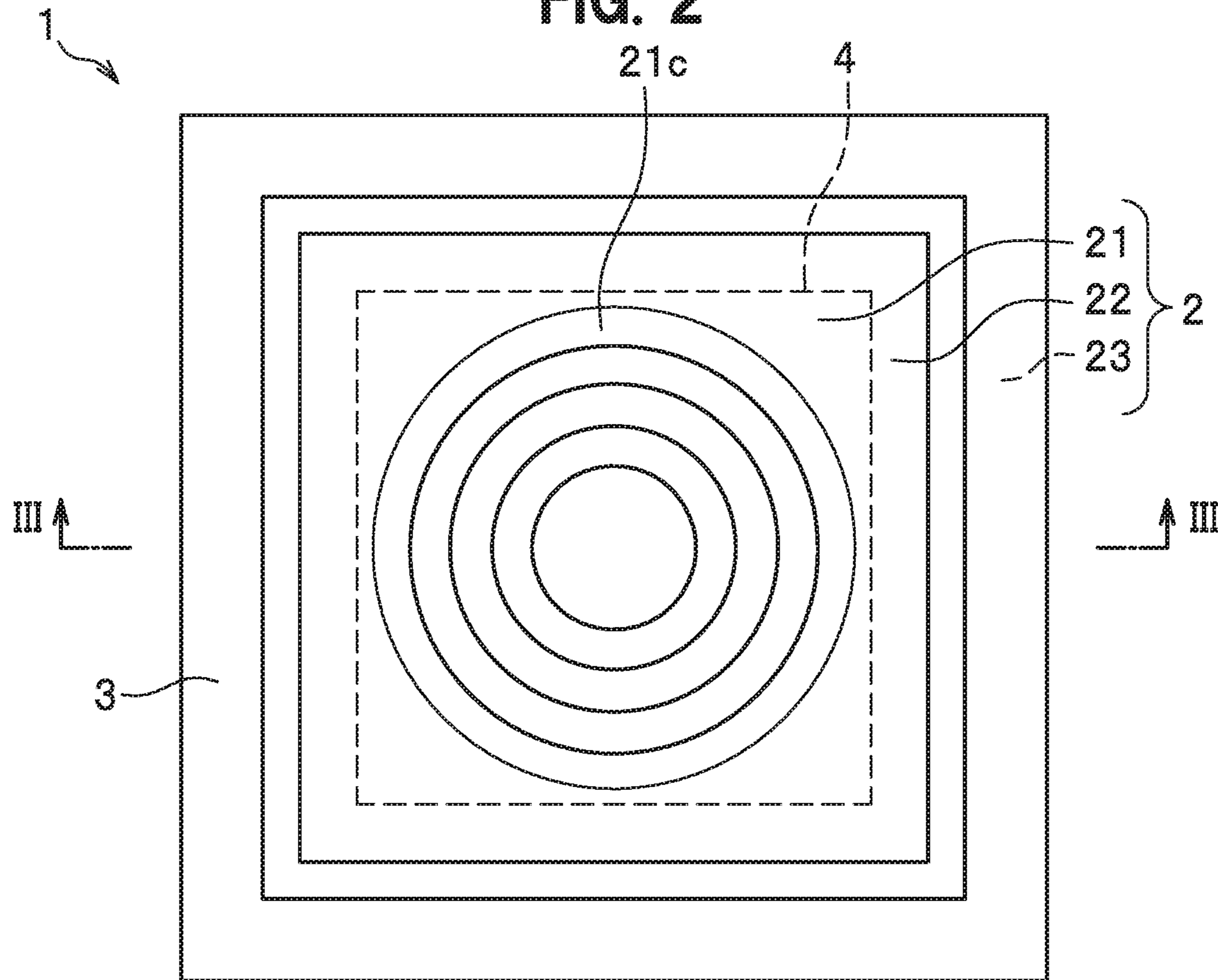


FIG. 3

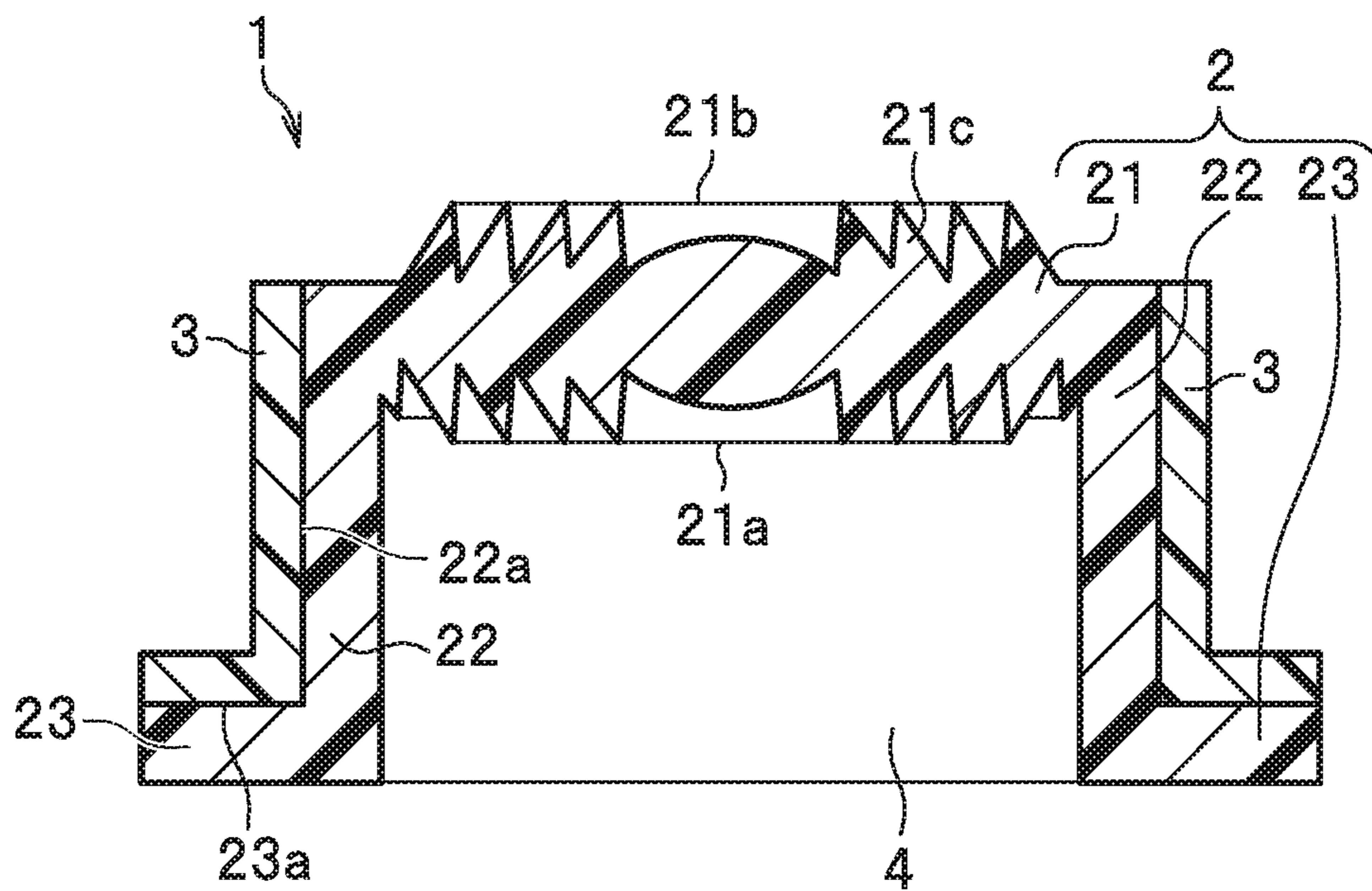


FIG. 4

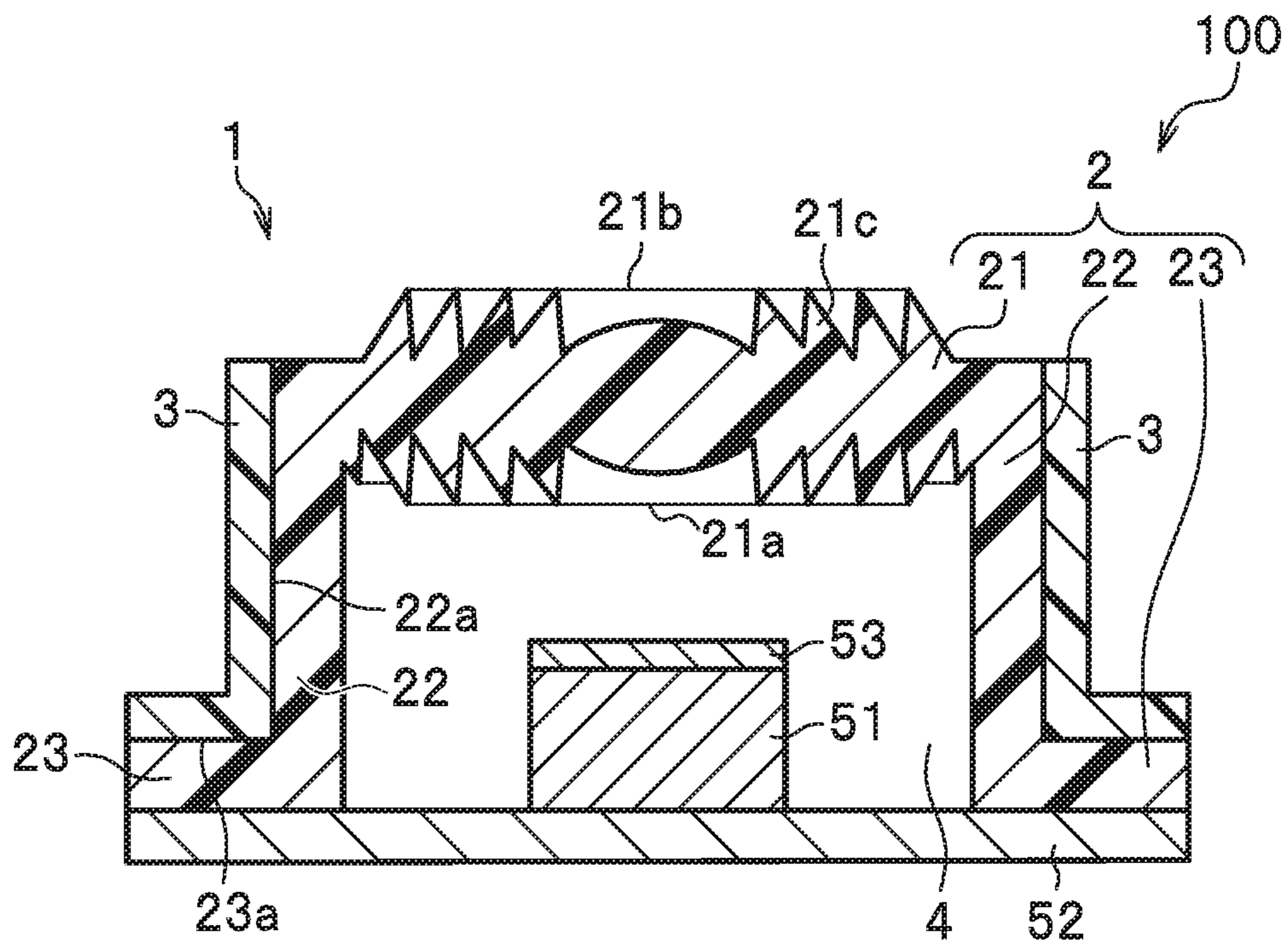


FIG. 5

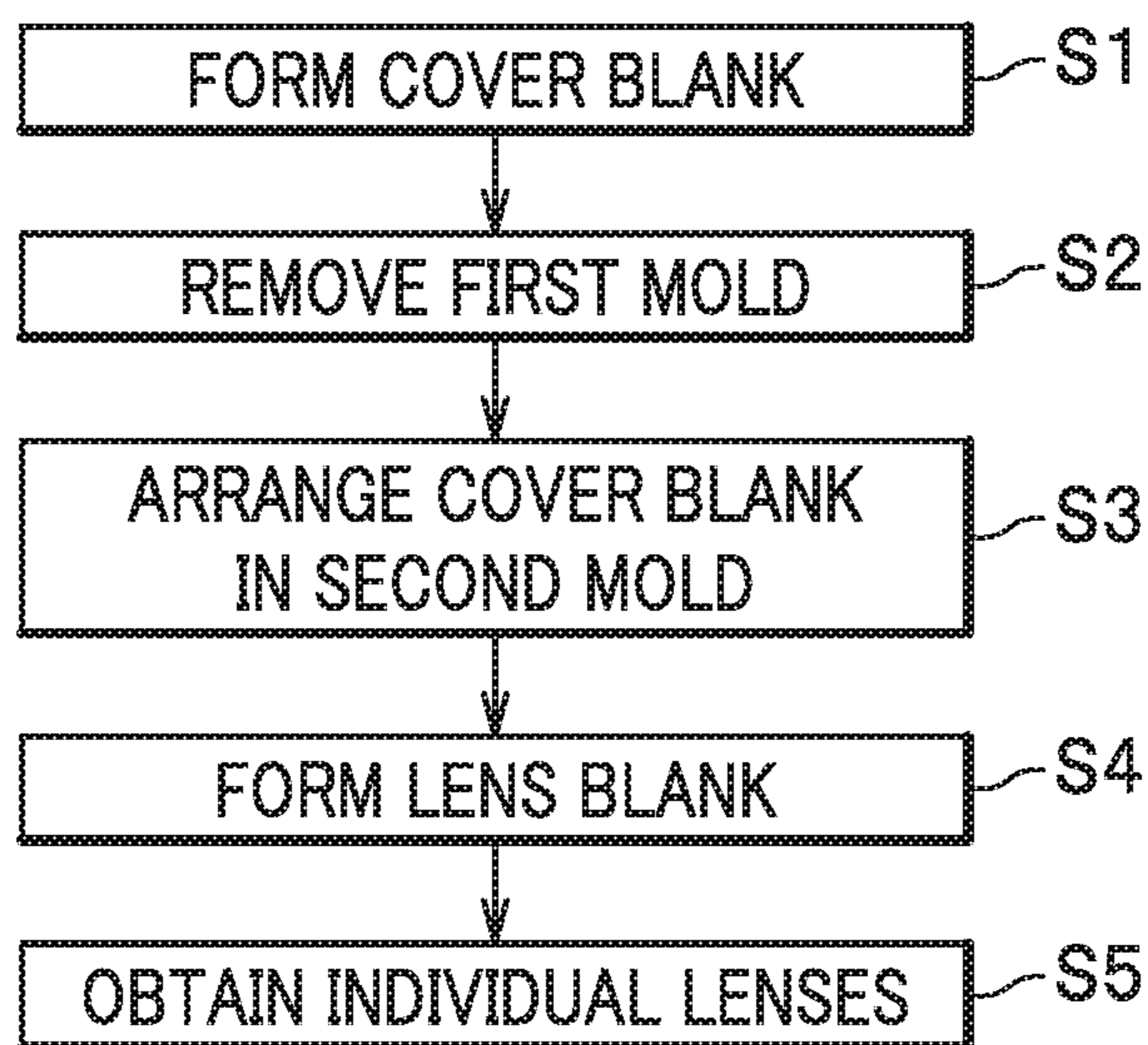


FIG. 6A

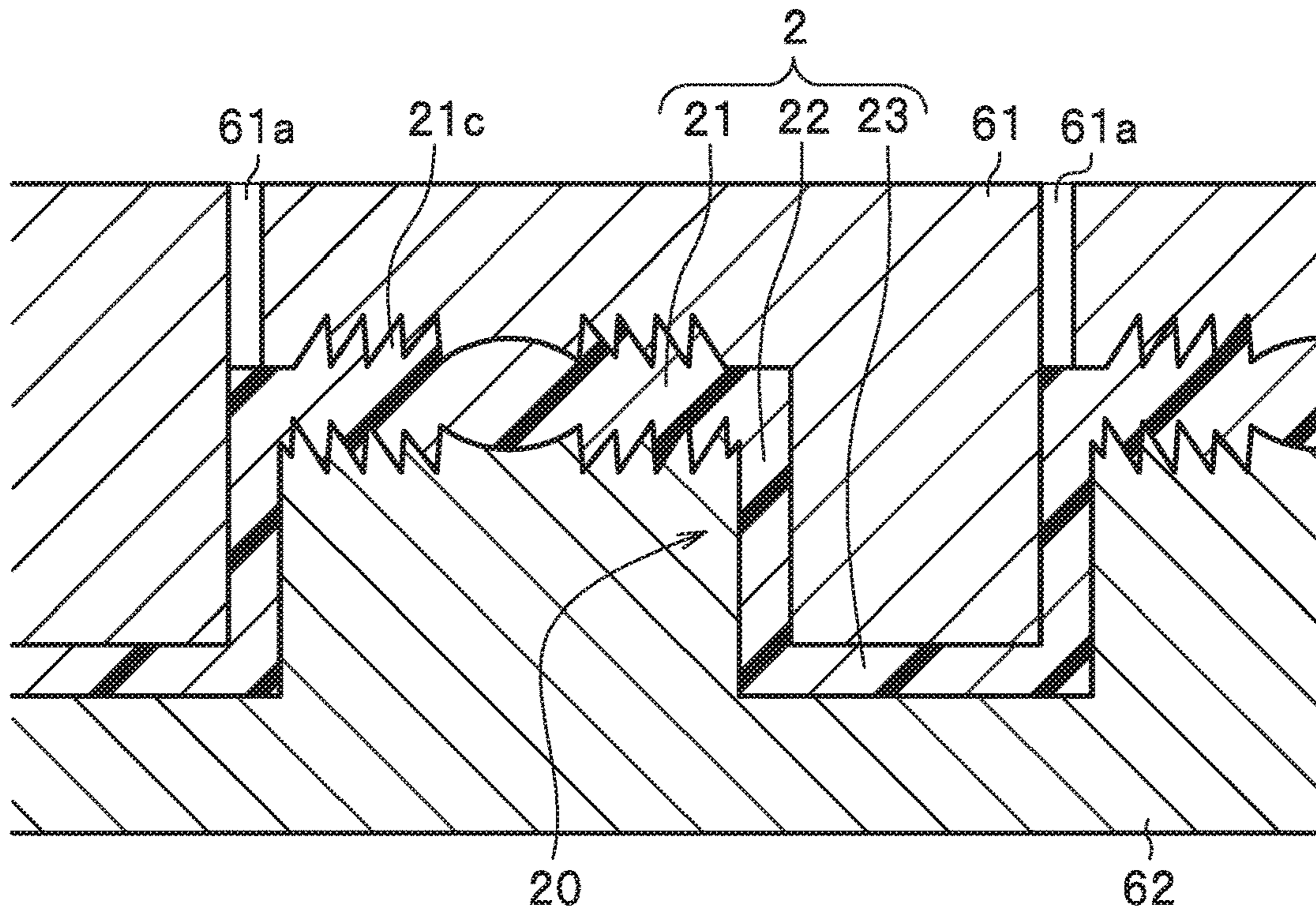


FIG. 6B

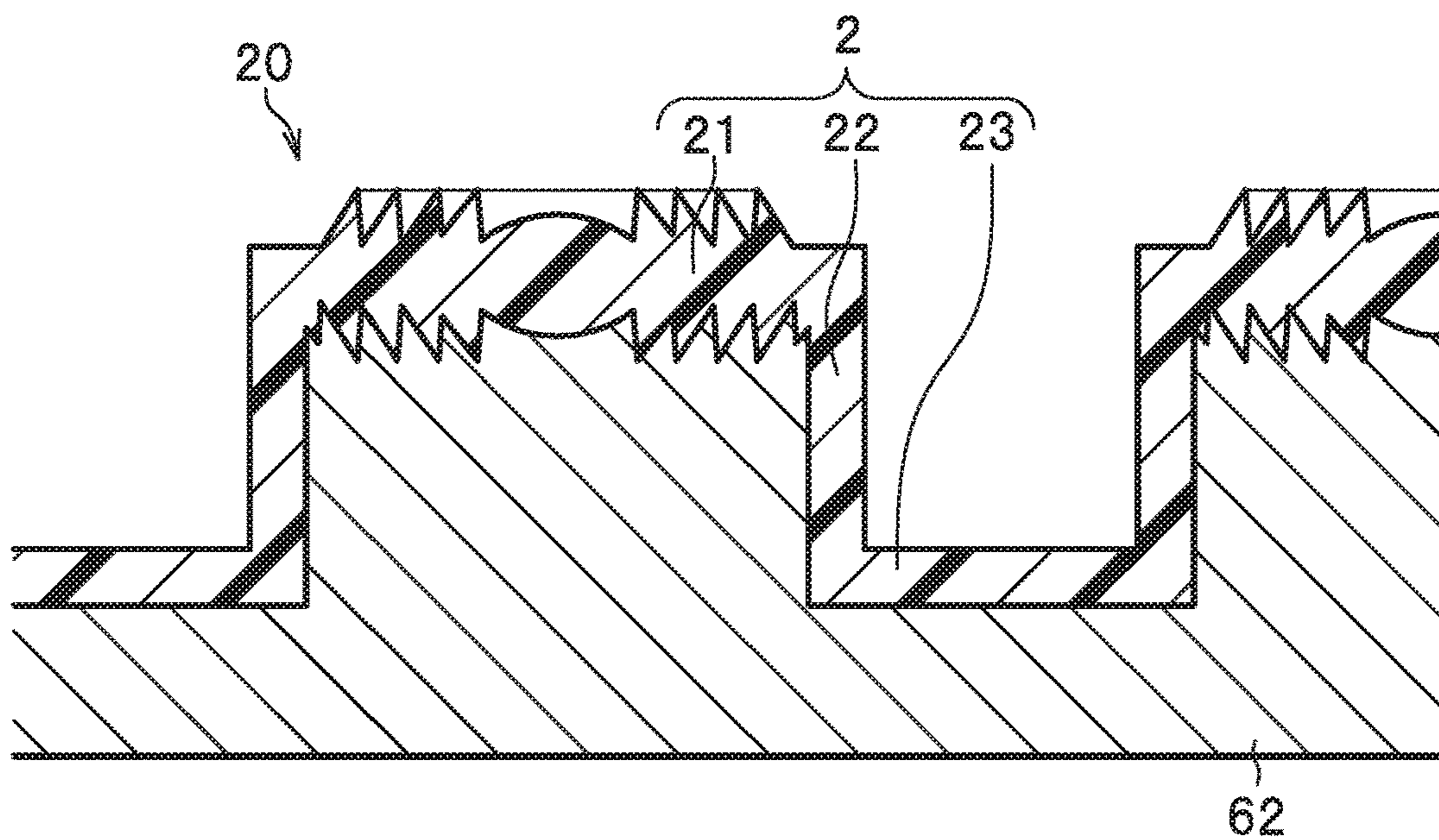


FIG. 6C

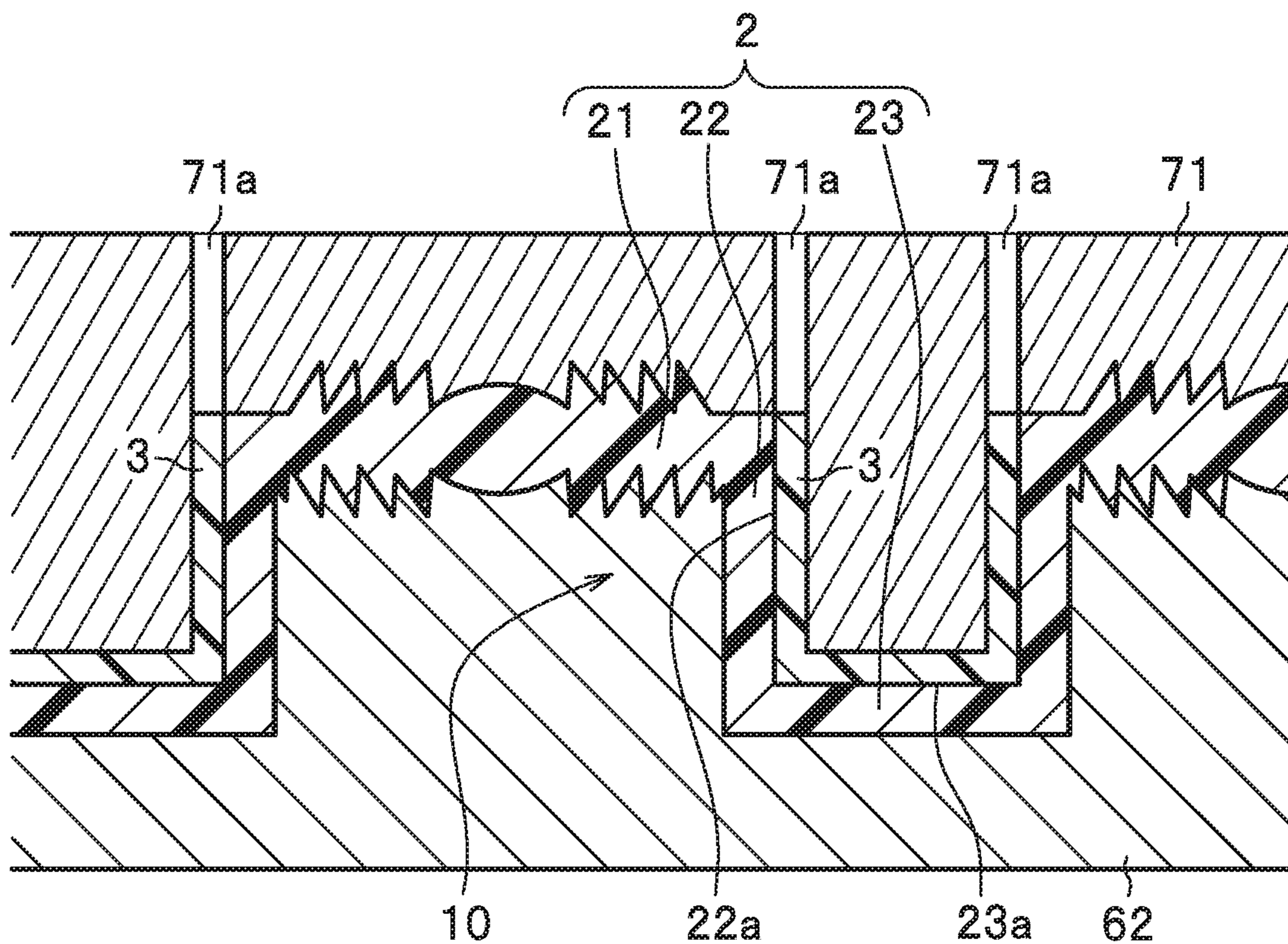


FIG. 6D

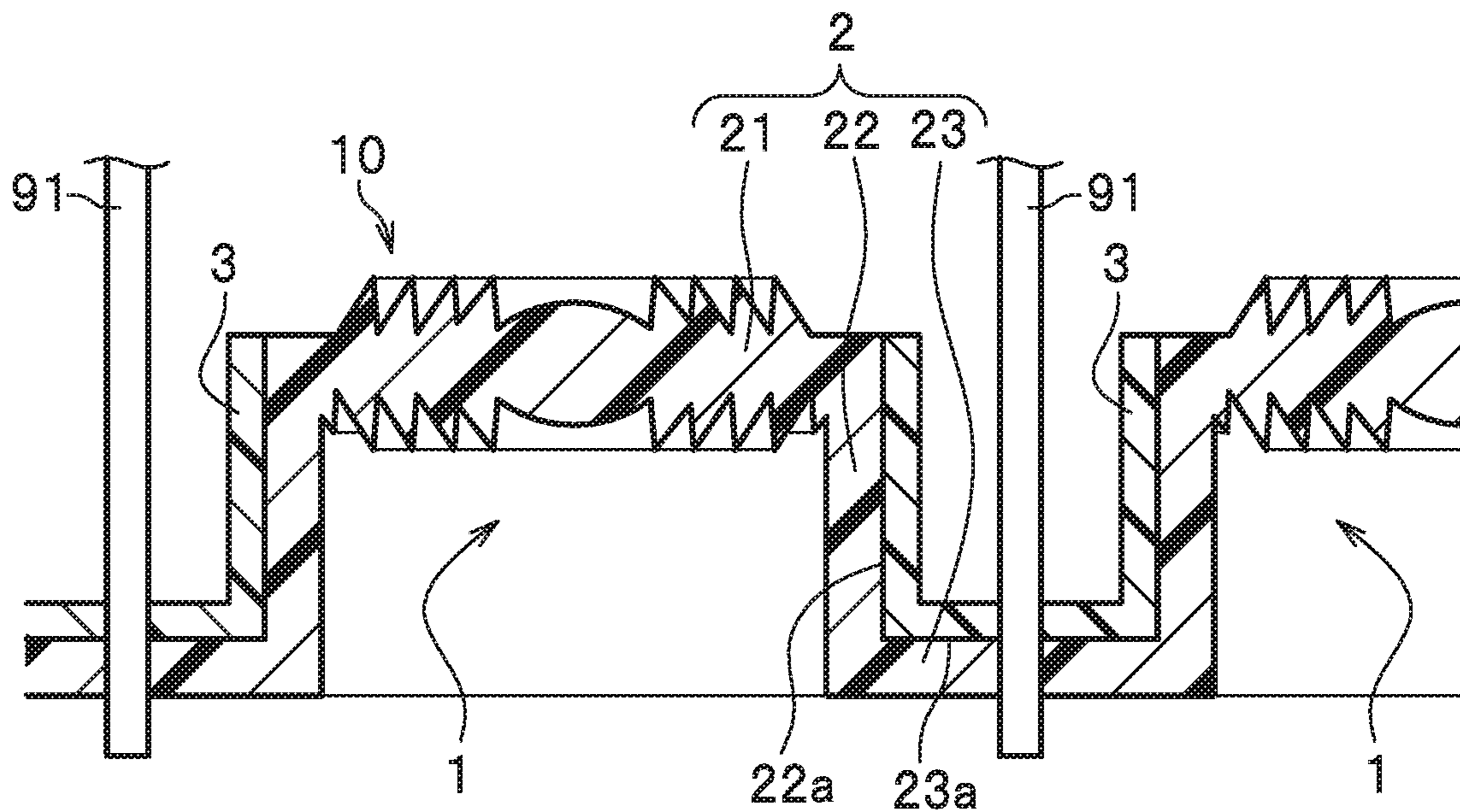


FIG. 7

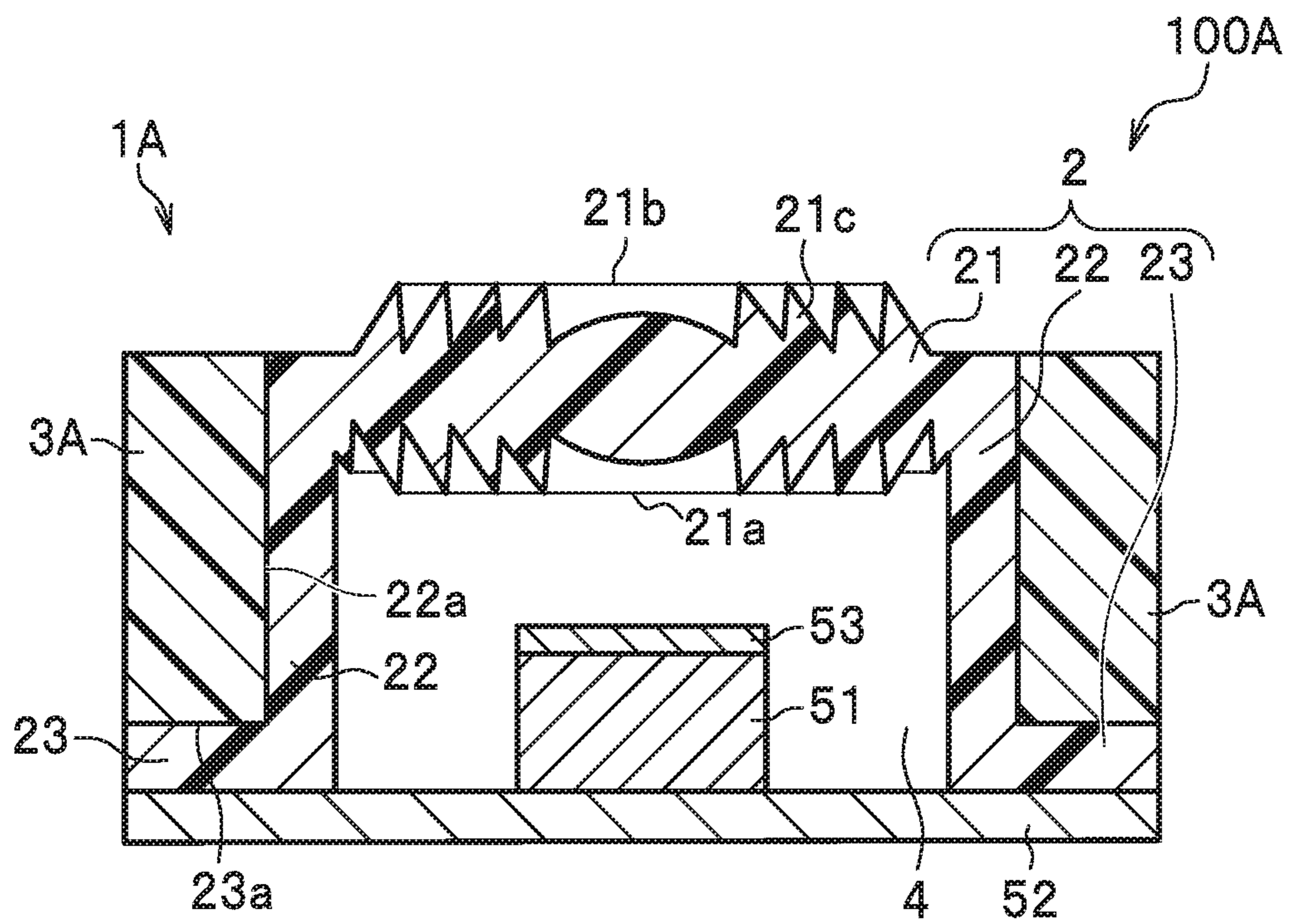


FIG. 8A

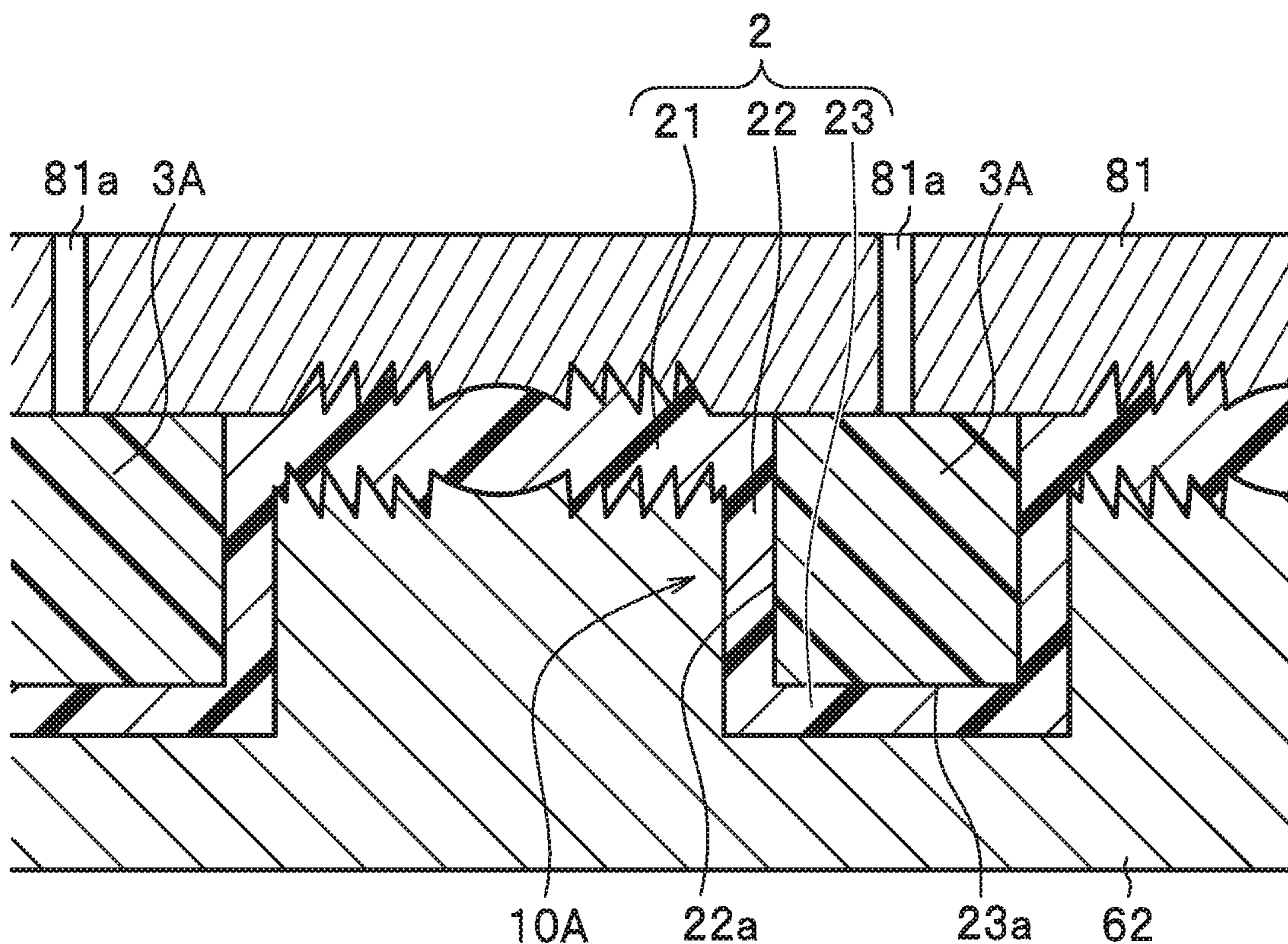


FIG. 8B

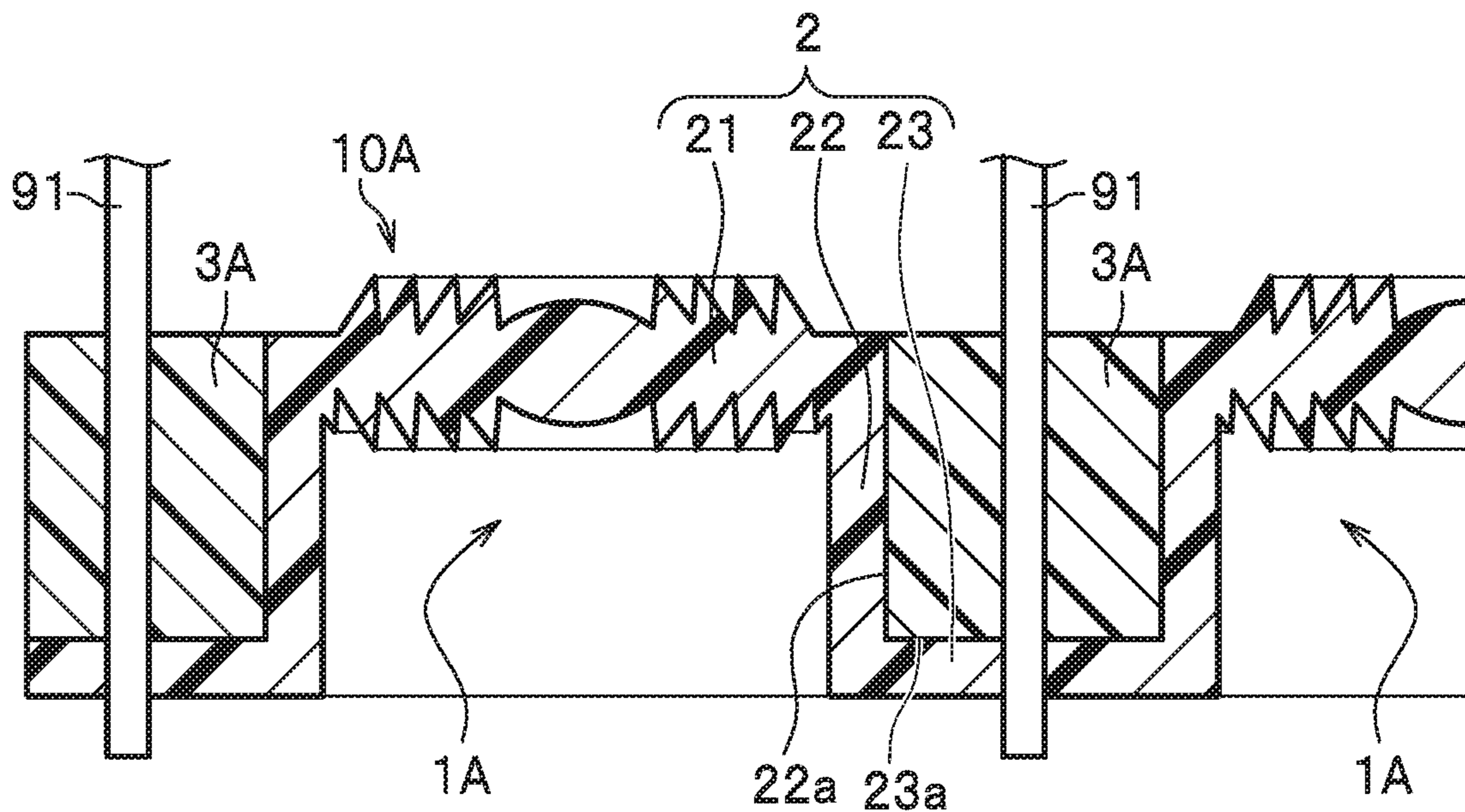


FIG. 9

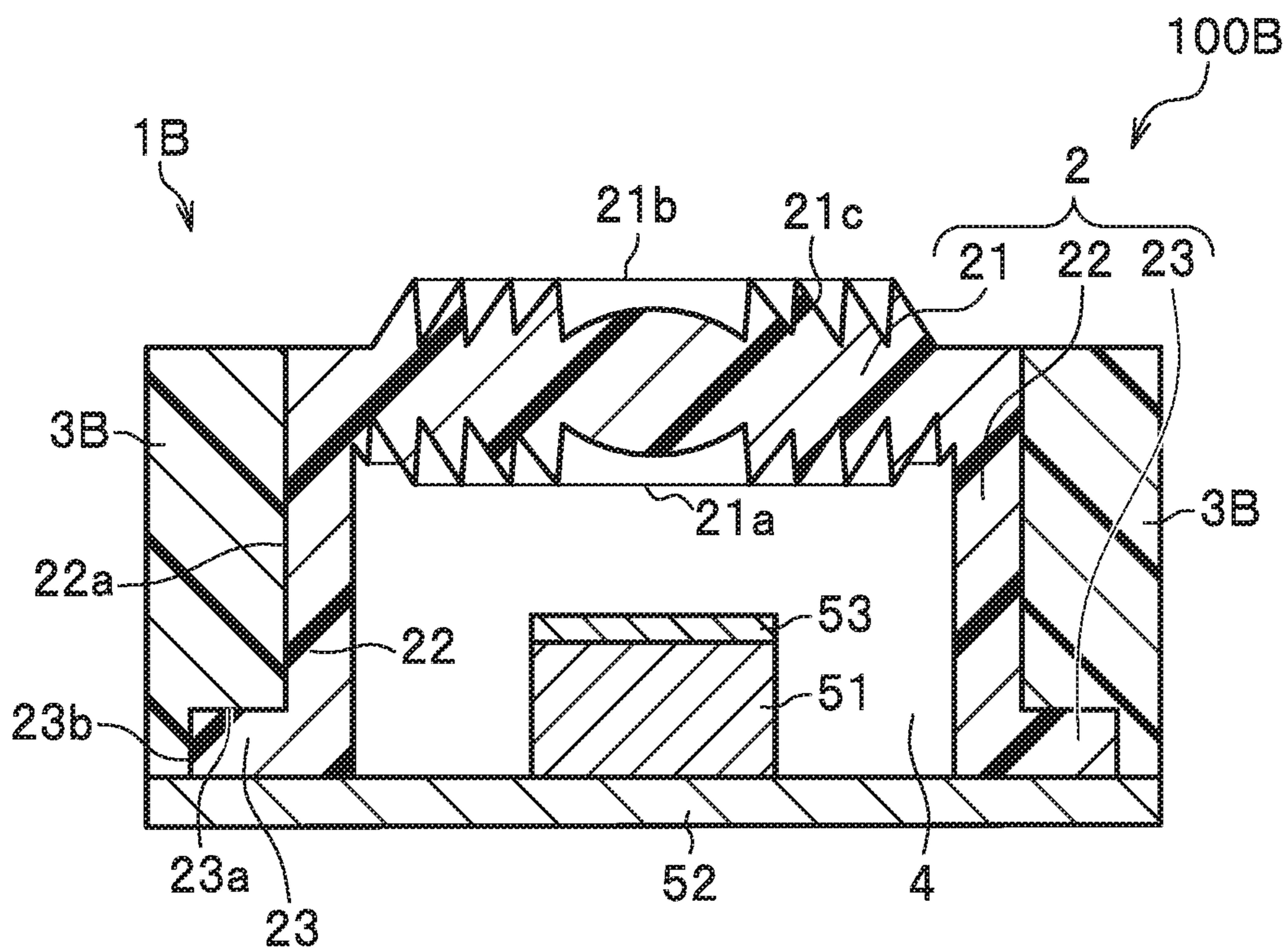


FIG. 10

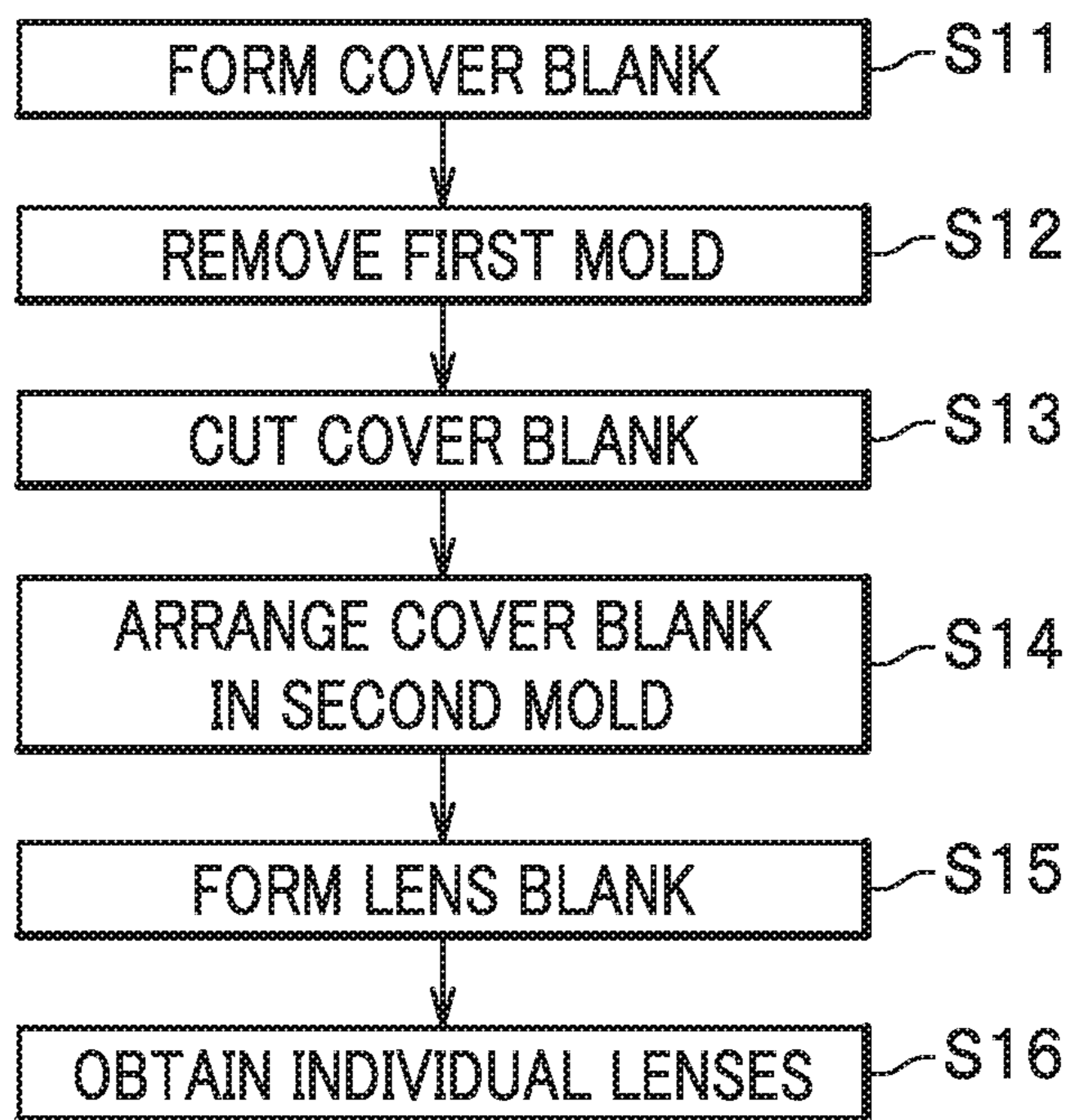


FIG. 11A

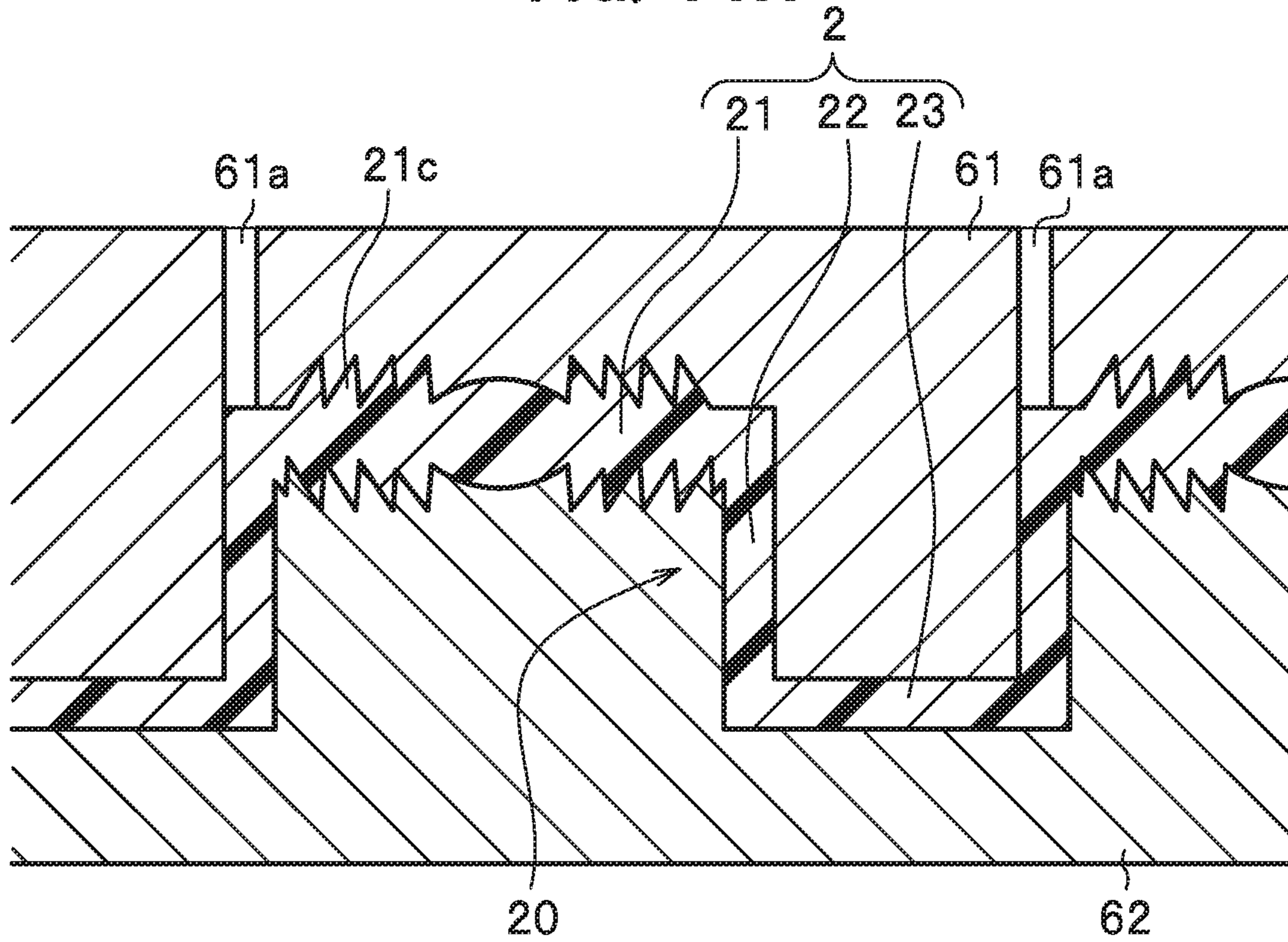


FIG. 11B

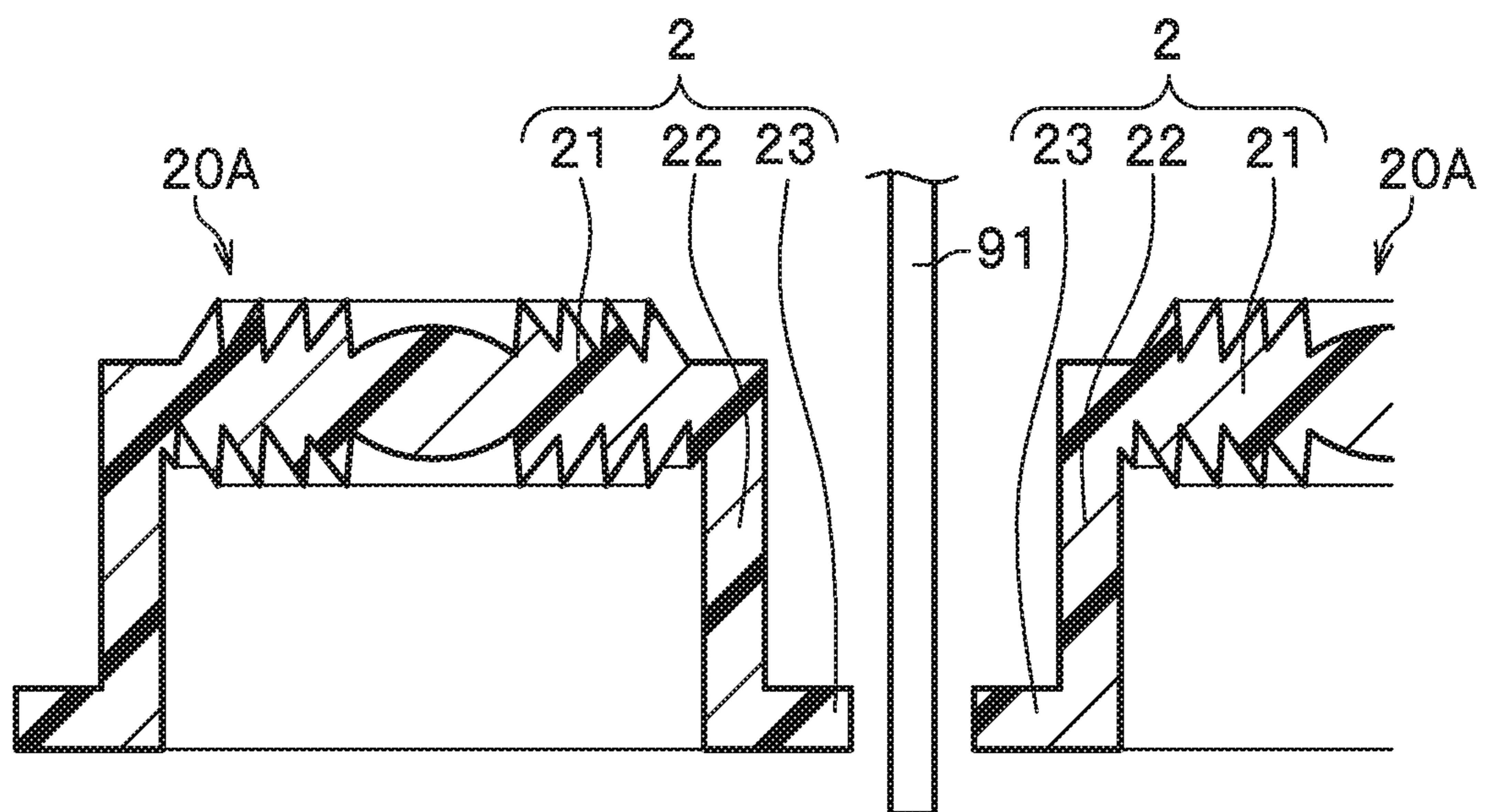


FIG. 11C

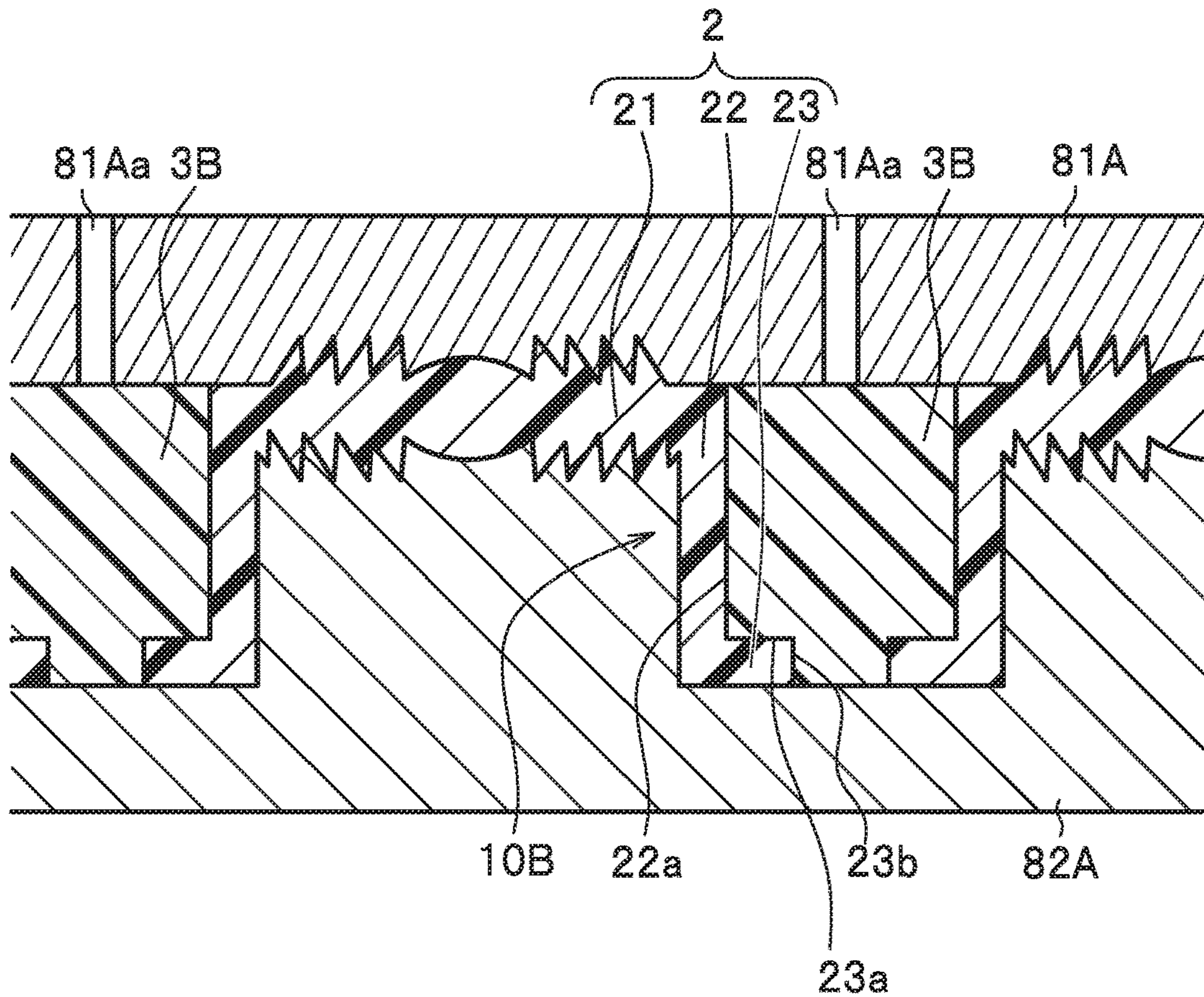


FIG. 11D

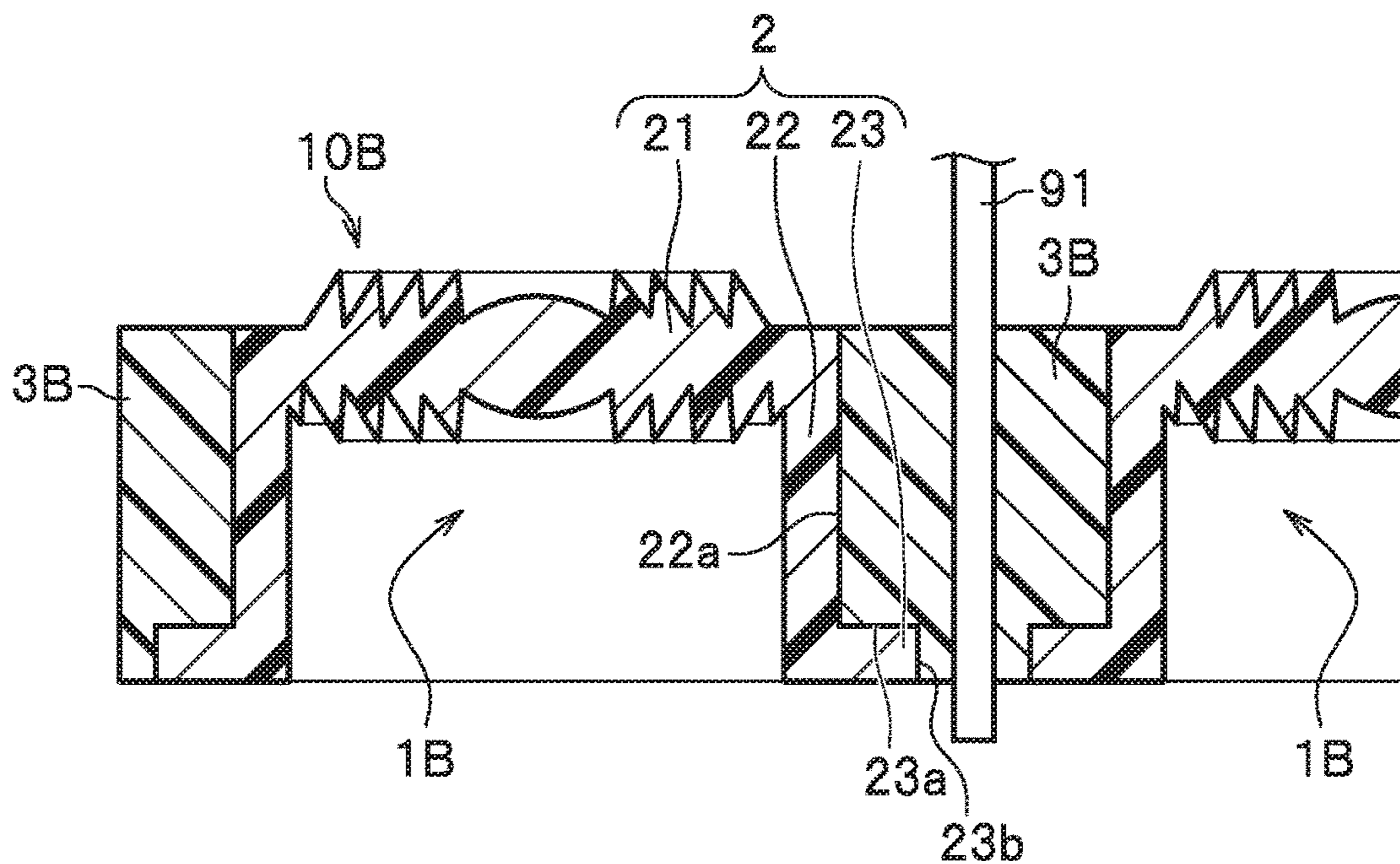


FIG. 12

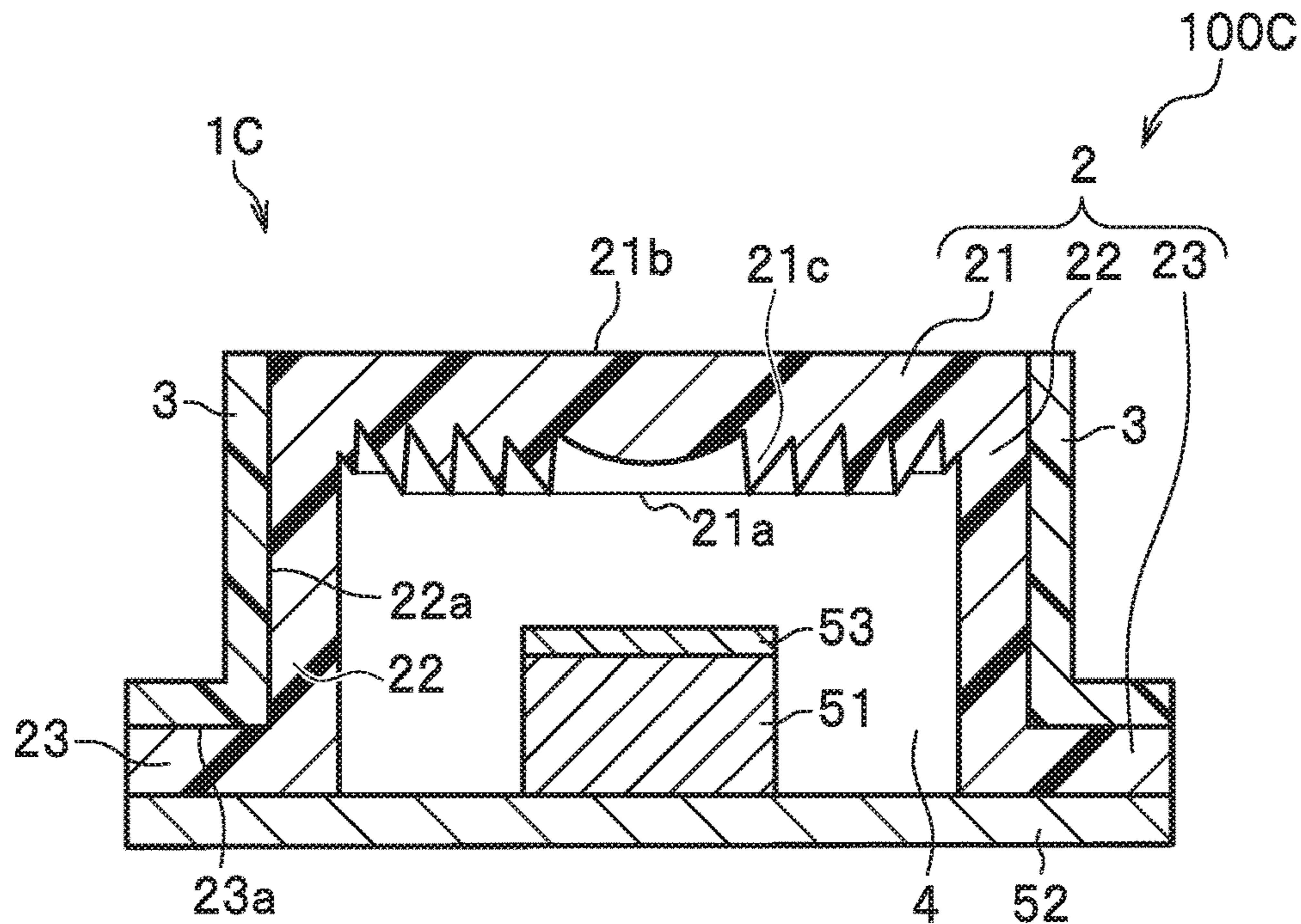
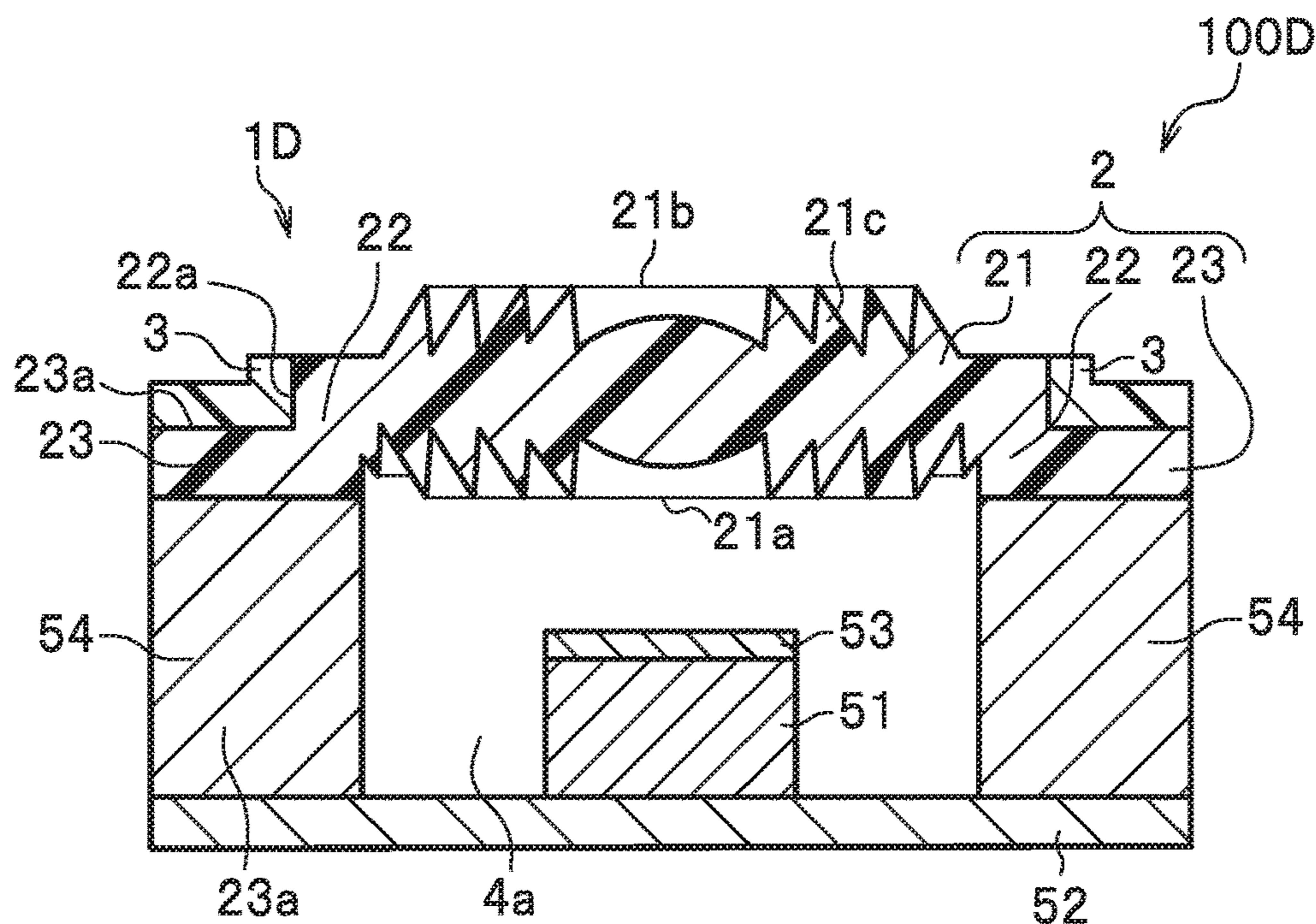


FIG. 13



**LENS, LIGHT EMITTING DEVICE AND
METHOD OF MANUFACTURING THE LENS
AND THE LIGHT EMITTING DEVICE**

CROSS-REFERENCE TO RELATED PATENT
APPLICATION

The present application claims priority under 35 U.S.C. § 119 to Japanese Patent Application No. 2018-162678, filed Aug. 31, 2018. The contents of Japanese Patent Application No. 2018-162678 are incorporated herein by reference in their entirety.

BACKGROUND OF THE INVENTION

Field of the Invention

The present disclosure relates to a lens and a light emitting device, and a method of manufacturing the lens and the light emitting device.

Discussion of the Background

Applications for flush light sources used in cellular phones and other mobile devices, a light emitting device may include an LED element mounted on a circuit board, a cover having an optical lens facing the LED element, and a light-reflecting member integrally formed with the cover, for example, described in Japanese patent publication No. 5139915. In the light emitting device described in Japanese patent publication No. 5139915, a metal film is used as the light-reflecting member and the metal film is formed by way of, for example, vacuum vapor deposition.

SUMMARY OF THE INVENTION

A lens according to one embodiment of the present disclosure includes a cover part and a light-shielding part. The cover part includes a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part. The lens part and the connection part define a recess opening downward, the lens part defines a bottom surface of the recess, and the connection part defines lateral surfaces of the recess and surrounding the opening of the recess. The flange part extends outward from a periphery of the recess. The lens part, the flange part, and the connection part are formed of a thermosetting first resin and continuous to one another. The light-shielding part covers an outer lateral side of the connection part and is formed of a thermosetting second resin having a greater light-absorptance or a greater light-reflectance than the first resin.

A lens according to one embodiment of the present disclosure includes a cover part and a light-shielding part. The cover part includes a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part. The lens part, the flange part, and the connection part are formed of a thermosetting first resin and continuous to one another, with a thickness of the flange part in a range of 5 μm to 30 μm . The light-shielding part covers an outer lateral side of the connection part and is formed of a second resin having a greater light-absorptance or a greater light-reflectance than the first resin.

A light emitting device according to one embodiment of the present disclosure includes a light emitting element and a lens. The lens includes a cover part and a light-shielding

part. The cover part includes a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part. The lens part and the connection part define a recess opening downward, the lens part defines a bottom surface of the recess and the connection part defines lateral surfaces of the recess and surrounding the opening of the recess. The flange part extends outward from a periphery of the recess. The lens part, the flange part, and the connection part are formed of a thermosetting first resin and continuous to one another. The light-shielding part covers an outer lateral side of the connection part and is formed of a thermosetting second resin having a greater light-absorptance or a greater light-reflectance than the first resin. The lens part is disposed at a location that allows light from the light emitting element to be transmitted through the lens part.

A light emitting device according to one embodiment of the present disclosure includes a light emitting element and a lens. The lens includes a cover part and a light-shielding part. The cover part includes a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to an outer periphery of the connection part. The lens part, the flange part, and the connection part are formed of a thermosetting first resin and continuous to one another, with a thickness of the flange part in a range of 5 μm to 30 μm . The light-shielding part covers an outer lateral side of the connection part and is formed of a second resin having a greater light-absorptance or a greater light-reflectance than the first resin. The lens part is disposed at a location that allows light from the light emitting element to be transmitted through the lens part.

A method of manufacturing a lens according to one embodiment of the present disclosure includes: forming a cover blank, the forming a cover blank including, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, the lens part and the connection part defining a recess opening downward, the lens part defining a bottom surface of the recess and the connection part defining lateral surfaces of the recess and surrounding the opening of the recess, the flange part extending outward from a periphery of the recess, and the lens part, the flange part, and the connection part being continuous to one another; removing a part or all parts of the first mold after forming the cover blank; arranging the cover blank in a second mold; forming a lens blank, the forming a lens blank including, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold, and curing the second resin, to form a lens blank having a light-shielding part between adjacent cover parts; and obtaining individual lenses, the obtaining individual lenses including, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part.

A method of manufacturing a lens according to one embodiment of the present disclosure includes: forming a cover blank, the forming a cover blank including, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection

part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, the lens part, the flange part, and the connection part being continuous to one another, with a thickness of the flange part in a range of 5 μm to 30 μm ; removing a part or all parts of the first mold after forming the cover blank; arranging the cover blank in a second mold; forming a lens blank, the forming a lens blank including, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold and curing the second resin, to form a lens blank having a light-shielding part between adjacent cover parts; and obtaining individual lenses, the obtaining individual lenses including, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part.

A method of manufacturing a lens according to one embodiment of the present disclosure includes: forming a cover blank, the forming a cover blank including, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, and, the lens part, the flange part, and the connection part being continuous to one another; removing the first mold after forming the cover blank; cutting the cover blank at the flange part located between adjacent cover parts; arranging the cut cover blank in a second mold; forming a lens blank, the forming a lens blank including, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold and curing the second resin to form a lens blank having a light-shielding part between adjacent cover parts; and obtaining individual lenses, the obtaining individual lenses comprising, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part and an outer end surface of the flange part covered by the light-shielding part.

A method of manufacturing a light emitting device according to one embodiment of the present disclosure includes providing a lens according one of the methods described above, and disposing the lens at a location that allows light from the light emitting element to be transmitted through the lens part of the lens.

BRIEF DESCRIPTION OF THE DRAWINGS

A more complete appreciation of the invention and many of the attendant advantages thereof will be readily obtained as the same becomes better understood by reference to the following detailed description when considered in connection with the accompanying drawings, wherein:

FIG. 1 is a perspective sectional view schematically showing a structure of a light emitting device that includes a lens according to a first embodiment, taken along a line passing through the center of the light emitting device;

FIG. 2 is a plan view schematically showing a structure of a lens according to the first embodiment;

FIG. 3 is a cross-sectional view, taken along line III-III of FIG. 2, schematically showing a structure of a lens accord-

ing to the first embodiment, in which the line is passing through the center of the lens;

FIG. 4 is a cross-sectional view schematically showing a structure of a light emitting device according to the first embodiment, taken along a line passing through the center of the light emitting device;

FIG. 5 is a flow chart showing a procedure of a method of manufacturing a lens according to the first embodiment;

FIG. 6A is a cross-sectional view schematically illustrating forming a cover blank in a method of manufacturing a lens according to the first embodiment;

FIG. 6B is a cross-sectional view schematically illustrating removing a first mold in a method of manufacturing a lens according to the first embodiment;

FIG. 6C is a cross-sectional view schematically illustrating arranging a cover blank in a second mold and forming a lens blank in a method of manufacturing a lens according to the first embodiment;

FIG. 6D is a cross-sectional view schematically illustrating cutting a lens blank to obtain individual lenses in a method of manufacturing a lens according to the first embodiment;

FIG. 7 is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a second embodiment, taken along a line passing through the center of the light emitting device;

FIG. 8A is a cross-sectional view schematically illustrating arranging a cover blank in a second mold to form a lens blank in a method of manufacturing a lens according to the second embodiment;

FIG. 8B is a cross-sectional view schematically illustrating cutting a lens blank to obtain individual lenses;

FIG. 9 is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a third embodiment, taken along a line passing through the center of the light emitting device;

FIG. 10 is a flow chart showing a procedure of a method of manufacturing a lens according to the third embodiment;

FIG. 11A is a cross-sectional view schematically illustrating forming a cover blank in a method of manufacturing a lens according to the third embodiment;

FIG. 11B is a cross-sectional view schematically illustrating cutting a cover blank in a method of manufacturing a lens according to the third embodiment;

FIG. 11C is a cross-sectional view schematically illustrating arranging a cut cover blank in a second mold and forming a lens blank in a method of manufacturing a lens according to the third embodiment;

FIG. 11D is a cross-sectional view schematically illustrating cutting a lens blank to obtain individual lenses in a method of manufacturing a lens according to the third embodiment;

FIG. 12 is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a fourth embodiment, taken along a line passing through the center of the light emitting device; and

FIG. 13 is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a fifth embodiment, taken along a line passing through the center of the light emitting device.

DESCRIPTION OF THE EMBODIMENTS

In the following, certain embodiments will be described with reference to the drawings. However, the embodiments shown below exemplify lenses, light emitting devices for embodying the technical idea of the present invention, and

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the technical idea of the present invention is not limited thereto. The sizes, materials, shapes and the relative positions of the members described in the embodiments are given as examples and are not as a limitation to the scope of the invention unless specifically stated. The sizes and positional relationships of the members in each of drawings are occasionally shown exaggerated for ease of explanation.

First Embodiment

FIG. 1 is a perspective sectional view schematically showing a structure of a light emitting device that includes a lens according to a first embodiment, taken along a line passing through the center of the light emitting device. FIG. 2 is a plan view schematically showing a structure of a lens according to the first embodiment. FIG. 3 is a cross-sectional view, taken along line III-III of FIG. 2, schematically showing a structure of a lens according to the first embodiment, in which the line is passing through the center of the lens. FIG. 4 is a cross-sectional view schematically showing a structure of a light emitting device according to the first embodiment, where the light emitting device is cut through its center.

The light emitting device 100 includes a light emitting element 51 and a lens 51. The light emitting device 100 further includes a substrate 52 on which the light emitting element 51 is mounted.

Lens

Lens 1 will be described.

The lens 1 includes a cover part 2 and a light-shielding part 3.

The cover part 2 of the lens 1 includes a lens part 21, a connection part 22 connected to an outer periphery of the lens part 21, and a flange part 23 connected to a lower-end portion of an outer periphery of the connection part 22. The lens part 21, the connection part 22, and the flange part 23 are formed of a thermosetting first resin and continuous to one another. The light-shielding part 3 of the lens 1 covers an outer lateral side of the connection part 22 and formed of a thermosetting second resin having a greater light-absorbance or a greater light-reflectance than the first resin. For example, the lens 1 is used as a flash lens for a cellular phone or the like.

Cover Part

The cover part 2 includes a lens part 21, a flange part 23, and a connection part 22, which are formed of the thermosetting first resin and continuous to one another. In the cover part 2, the lens part 21 and the connection part 22 define a recess 4 opening downward, and the flange part 23 extends outward from a periphery of the recess 4.

The lens part 21 is a member through which light from the light emitting element 51 can be emitted to the outside in parallel light, condensed light, or diffused light. The lens part 21 has a light incidence surface 21a for receiving light emitted from the light emitting element 51 enters, and a light emitting surface 21b at an opposite side to the light incidence surface 21a, where the incident light is refracted and is emitted to the outside.

The outer shape in a plan view of the lens part 21 can be selected from various appropriate shapes, examples thereof include a polygonal shape such as a quadrangular shape, a hexagonal shape, and an octagonal shape, a circular shape and an elliptic shape. A center portion of the lens part 21 that

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serves as a lens preferably has a circular shape or an elliptic shape, where a circular shape is more preferable. The lens part 21 has a maximum thickness of, for example, in a range of 0.1 mm to 10 mm, preferably in a range of 0.5 mm to 5 mm.

For the lens part 21, a Fresnel lens, a total internal reflection (TIR) lens, or the like can be used, in which, a Fresnel lens is preferable. The Fresnel lens 21 may have either a single lens-center or a plurality of lens-centers. When a plurality of Fresnel lenses 21 are employed, the Fresnel lenses are arranged corresponding to the arrangement of the light emitting elements 51, such that an odd number of Fresnel lenses are preferably arranged in a zigzag form, and an even number of Fresnel lenses are preferably arranged in a square matrix form.

The Fresnel lens 21 includes a plurality of concentric circles of ridges 21c on the light incidence surface 21a and on the light emitting surface 21b. When combined, the cross-sectional shapes of the plurality of ridges 21c form a lens curved surface of a single convex lens. The plurality of ridges 21c are preferably arranged in concentric circles or concentric ellipsoids in a radial direction of the Fresnel lens 21. In the Fresnel lens 21, the base plane of the plurality of ridges 21c can be flat, or concave or convex.

Each of the ridges 21c has a profile formed with a straight portion at the center-side and a segment of lens curve at the outer-side. The profile of each of the ridges 21c may be formed with inwardly curved segment either a concave curve or a convex curve, in conformity to the direction of light to be emitted. The angles (Fresnel angles) at the tips of the ridges 21c are adjusted such that light from the light emitting element 51 is emitted to the outside in parallel light.

The connection part 22 is connected to the lateral sides of the lens part 21 such that an upper end portion of the connection part 22 is contiguous to an upper end portion of the lateral sides of the lens part 21, and the connection part 22 is extended downward in a right angle with respect to the lens part 21, and a lower-end portion of the connection part 22 is contiguous to the flange part 23 in, for example, a right angle. The connection part 22 and the lens part 21 define a recess 4 opening downward to accommodate a light emitting element 51. In a cross-sectional view, the recess 4 is preferably a rectangular U-shape, but a semicircular shape or a semi-elliptical shape can also be employed. The lens part 21 has a rectangular outer peripheral shape in a plan view, such that the connection part 22 is disposed with respect to all the sides of the connection part 22, in which each two opposite sides of the connection part 22 are substantially in parallel to each other. The lens part 22 has a thickness of, for example, in a range of 50 μm to 200 μm , preferably in a range of 50 μm to 100 μm . The connection part 22 is preferably formed such that the lens part 21 locates at a center of a bottom surface of the recess.

The flange part 23 is formed contiguous to a lower-end portion of a corresponding one of the plurality of outer lateral sides of the connection part 22, and extends outward at a substantially right angle with respect to the corresponding outer lateral side of the connection part 22. The flange part 23 is, preferably a plate-shaped member surrounding the outer periphery of the connection part 22, and is used to be bonded or secured to the substrate 52 having the light emitting element 51 mounted thereon.

The flange part 23 preferably has a thickness in a range of 5 μm to 30 μm . The flange part 23 has a thickness reduced to the range of 5 μm to 30 μm , such that when used as a lens 1, leaking of light to a lateral side of the lens 1, particularly

leaking of light through the flange part **23** can be reduced. The flange part **23** preferably has a thickness not greater than 20 μm .

The length of the flange part **23** protruded outward from the lower end of the connection part **22** is preferably in a range of 200 μm to 3,000 μm . With this arrangement, stable bonding or stable securing of the flange part **23** with the substrate **52** can be obtained. Further, bonding to the substrate **52** can be facilitated by applying an adhesive material on the flange part **23**.

The first resin used for the cover part **2** is preferably a light-transmissive thermosetting resin. Examples of the thermosetting resin include a phenol resin, a urea resin, a melamine resin, epoxy resin, a silicone resin, a polyurethane resin, etc., and a silicone resin is preferably used. Thus, compared to conventionally-used thermoplastic resin such as polycarbonate, the use of thermosetting resin having higher optical resistance and/or thermal resistance can reduce degradation of the cover part **2**, and further, can reduce degradation with passage of time, in which exponentially developing blackening due to concentration of light and heat in portions that discolored by degradation. Further, silicone resin exhibits a low viscosity, which can facilitate molding of the flange part **23** with a small thickness.

Light-Shielding Part

The light-shielding part **3** covers an outer lateral surfaces **22a** of the connection part **22** and an upper surface **23a** of the flange part **23**. The light-shielding part **3** is formed of the second resin having a greater light absorptance or a greater light reflectance than the first resin.

The light-shielding part **3** is formed along the shape of the connection part **22** and the flange part, with a substantially uniform thickness. More specifically, the light-shielding part **3** has a cross-sectional shape along the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23**, and for example, a cross-sectional shape of an L-shape. The light-shielding part **3** preferably has a thickness; that is, a thickness normal to a lateral surface of the connection part **22** or a thickness normal to the upper surface of the flange part **23**, in a range of 200 μm to 3,000 μm . With this arrangement, the light-shielding part **3** can reliably cover the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23** such that light is not transmitted through the light-shielding part **3**. The light-shielding part **3** is disposed on the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23**, without using an adhesive. Because an adhesive is not used, degradation and/or detachment of an adhesive, and/or absorption of light by the adhesive does not occur.

The light-shielding part **3** is formed of a second resin that is a thermosetting resin having a greater light-absorptance or a greater light-reflectance than the light-transmissive first resin. The second resin **3** is a black resin or a white resin, which is made of a light-transmissive thermosetting resin similar to that used for the first resin, preferably a silicone resin, to which a black material such as carbon having a high light-absorptance or a white material such as titanium oxide having a high light-reflectance is contained. Accordingly, the connection part **22** formed of the light-transmissive first resin is covered by the light-shielding part **3** formed of the

second resin having a higher light-absorptance or light-reflectance than that of the first resin.

Light Emitting Device

Next, the light emitting device **100** will be described.

The light emitting device **100** includes a light emitting element **51**, a lens **1** having a lens part **21**, and preferably a substrate **52**, and the lens part **21** is disposed at a location that allows light from the light emitting element to be transmitted through the lens part **21**. The light emitting device **100** may further include a light-transmissive member **53**. The light emitting device **100** has a lens **1** surrounded by the light-shielding part **3** such that light from the light emitting element **51** is absorbed or reflected by the light-shielding part **3**, thus, leaking of light in a lateral side of the lens **1** can be reduced. The lens **1** has been described above, description thereof will be appropriately omitted.

Light Emitting Element

The light emitting element **51** at least includes a nitride semiconductor layered structure. The nitride-based semiconductor layered structure includes the first semiconductor layer (for example, an n-type semiconductor layer), a light emitting layer, and a second semiconductor layer (for example, a p-type semiconductor layer) layered in this order, which generates light. The nitride semiconductor layered body preferably has a thickness not greater than 30 μm .

The materials of the first semiconductor layer, the active layer, and the second semiconductor layer can be appropriately selected. Examples thereof include a Group III-V compound semiconductor and a Group II-VI compound semiconductor. Specific examples include nitride-based semiconductor materials such as $\text{In}_x\text{Al}_y\text{Ga}_{1-x-y}\text{N}$ ($0 \leq x$, $0 \leq y$, $x+y \leq 1$); for example, InN, AlN, GaN, InGaN, AlGaIn, or the like can be used. For the fluorescent material, a known material in the art can be used. The light emitting elements **51** may generally has a quadrangular shape, but may have a circular shape, an elliptical shape, or a polygonal shape such as a triangular shape or a hexagonal shape.

Light-Transmissive Member

It is preferable that an upper surface of the light emitting element **51** is covered by a light-transmissive member **53**, which can be disposed by using a spraying method or the like. The light-transmissive member **53** is configured to protect the light emitting element **51** against external force, dust, moisture, or the like, while improving heat-resisting property, weather-resisting property, and light-resisting property of the light emitting element **51**. The light-transmissive member **53** preferably transmit 60% or greater light emitted from the light emitting layer. Such light-transmissive member can be formed of a thermosetting resin, a thermoplastic resin, a modified resin of such a resin, a hybrid resin which includes one or more of those resins, or the like. More specifically, an epoxy/modified epoxy resin, a silicone/modified silicone/hybrid silicone resin or the like, can be used.

In order to adjust the color of emitting light, the light-transmissive member **53** preferably include a fluorescent material that can convert the wavelength of light emitted from the light emitting element **51**. For the fluorescent material, a known material in the art can be used. Specific

examples thereof include an yttrium aluminum garnet (YAG)-based fluorescent material activated with cerium.

The light-transmissive member **53** may contain a filler (for example, a diffusion agent, a coloring agent, or the like). Examples of the filler material include silica, titanium oxide, zirconium oxide, magnesium oxide, glass, a crystal or sintered body of a phosphor, and a sintered body of a phosphor and an inorganic binding material.

Substrate

The substrate **52** is configured to mount the light emitting element **51** and made of a known base material such as sapphire, spinel, SiC, or the like, provided with a wiring pattern.

The light emitting elements **51** is preferably mounted on the substrate **52** in a flip-chip manner. Either a single or a plurality of light emitting elements **51** may be mounted on the substrate **52**. A plurality of light emitting elements **51** may be arranged either randomly or regularly such as in a matrix, or periodically. The plurality of light emitting elements may be connected either in series, in parallel, serial-parallel, or parallel-serial.

Arrangement of Light Emitting Element and Lens

The lens **1** is disposed at a location that allows light from the light emitting element **51** to be transmitted through the lens part **21**. The lens **1** is disposed on the substrate **52** through the flange part **23**, with the lens part **21** facing the light emitting element **51**. Accordingly, the lens **1** is disposed on the substrate **52** with the lens part **21** facing the light emitting element **51**, such that light from the light emitting element **51** leaking through the flange part **23** in lateral sides of the lens **1** can be reduced.

The light emitting element **51** is disposed spaced apart from the lens part **21** and the connection part **22**. More specifically, a depth of the recess defined by the lens part **21** and the connecting part **22** is in a range of about 0.4 mm to 1.5 mm, such that a distance between the bottom surface of the recess **4** and an upper surface of the light emitting element **51** is in a range of about 0.05 mm to 0.5 mm. With this arrangement, heat from the light emitting element **51** can be prevented from directly conducted to the lens part **21** and thermal degradation of the lens part **21** can be reduced.

In the lens **1**, the connection part **22** is formed such that a distance from the lens part (Fresnel lens) **21** to the light emitting element **51** is smaller than a distance from the connection part **22** to the light emitting element **51**. In the lens **1**, a recess **4** is defined by the lens part (Fresnel lens) **21** and the connection part **22** such that a distance from the lens part (Fresnel lens) **21** to the light emitting element **51** is smaller than a distance from the connection part **22** to the light emitting element **51**. More specifically, the center of the light emitting element **51** (or a geometrical center of the light emitting element **51**) is opposite to the center of the Fresnel lens **21** (or a geometrical center of the Fresnel lens **21**). In other words, the lens **1** is disposed such that the centers of the ridges **21c** of the lens **1** arranged in concentric circles or concentric ellipsoids and the center of the light emitting element **51** are aligned. When a compound lens including a plurality of lens parts **21** is used, the positions of the light emitting elements **51** may be shifted such that the centers of the light emitting elements **51** come closer to the center of the lens as a whole. With the arrangements of the light emitting element **51** described above, a certain gap can be maintained between the light emitting element **51** and the

connection part **22** and between the light emitting element **51** and the flange part **23**, such that light of the light emitting element **51** passing through the flange part **23** can be reduced.

Method of Manufacturing Lens

Next, a method of manufacturing a lens will be described.

FIG. **5** is a flow chart showing a procedure of a method of manufacturing a lens according to the first embodiment. FIG. **6A** is a cross-sectional view schematically illustrating forming a cover blank in a method of manufacturing a lens according to the first embodiment. FIG. **6B** is a cross-sectional view schematically showing removing a first mold in a method of manufacturing a lens according to the first embodiment. FIG. **6C** is a cross-sectional view schematically illustrating arranging a cover blank in a second mold and forming a lens blank in a method of manufacturing a lens according to the first embodiment. FIG. **6D** is a cross-sectional view schematically illustrating forming a Lens blank in a method of manufacturing a lens according to the first embodiment.

FIG. **6A** to FIG. **6D** illustrate producing a plurality of lens at once, but description below focuses on a single lens and description of other adjacent lenses will be omitted.

The method of manufacturing the lens **1** includes forming (S1) a cover blank, removing (S2) a first mold, arranging (S3) the cover blank in a second mold, forming (S4) a lens blank, and obtaining (S5) individual lenses, which are performed in this order. According to the method of manufacturing, the lens **1** with reduced leaking of light can be obtained.

The materials and positional arrangement of respective members are as those described for the lens **1**, and therefore the description thereof may be appropriately omitted.

Forming Cover Blank

In the forming (S1) a cover blank, a thermosetting first resin is injected in a first mold to form a cover blank **20** having a plurality of cover parts **2** each having a lens part **21**, a connection part **22** connected to an outer periphery of the lens part **21**, and a flange part **23** connected to an outer periphery of the connection part **22**, in which the lens part **21**, the connection part **22**, and the flange part **23** are formed continuous with one another.

In the forming (S1) a cover blank, for the first mold, an upper mold **61** and a lower mold **62** adapted for transfer molding is employed. The upper mold **61** and the lower mold **62** are closed, and the first resin, which is heated and softened, is injected under pressure into the first mold through a resin injection port **61a** formed in the upper mold **61**. The first resin is cured in the mold and a cover blank **20** in which a plurality of cover parts **23** are connected to one another through the flange part **23** is formed.

In the forming (S1) a cover blank, the upper mold **61** and the lower mold **62** are designed such that a molded product of the cover blank **20** includes a plurality of cover parts **2** each formed with a recess **4** defined by a lens part **20** and a connection part **22** with an opening end inward of the flange part **23**. Each of the lens parts **21** in the molded product of the cover blank **20** has a plurality of ridges **21c** on both the surfaces of the lens part **21**. Further, the upper mold **61** and the lower mold **62** are designed such that a molded product of the cover blank **20** includes a plurality of cover parts **2** each having a flange part **23** with a thickness in a range of, for example, 5 μm to 30 μm .

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Removing First Mold

In the removing (S2) the first mold, after the cover plank **20** is formed, a part or an entire of the first mold is removed. In the first embodiment, the upper mold **61**, which is a part of the first mold, is removed and the molded product of the cover blank **20** is held by the lower mold **62**.

Arranging Cover Blank in Second Mold

In the arranging (S3) a cover blank in a second mold, a different second upper mold **71** that is also adapted for transfer molding similarly as the first mold is arranged on the lower mold **62** holding the cover blank **20**. In the first embodiment, the second upper mold **71** and the lower mold **62** are used as the second mold.

Forming Lens Blank

In the forming (S4) a lens blank, a second resin having a light-absorbance or a light-reflectance higher than that of the first resin is injected in the second mold and cured to form a lens blank **10** having light-shielding part **3** formed between adjacent cover parts **2**.

In the forming a lens blank: S4, the upper mold **71** and the lower mold **62** are closed, and the second resin, which is heated and softened, is injected under pressure into the second mold through a resin injection port **71a** formed in the upper mold **71**. The second resin is cured in the heated mold, such that a lens blank **10** having the light-shielding part **3** formed in a shape that is bent in conformity to the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23** is molded.

Obtaining Individual Lenses

In the obtaining (S5) individual lenses, the lens blank **10** is singulated into individual lenses **1**. That is, the obtaining individual lenses: S5, all parts of the second mold are removed to take out the lens blank **10**, and the lens blank **10** is cut along a center of the light-shielding part **3** formed between adjacent cover parts **2**. Accordingly, individual lenses **1** each having outer sides of the connection part **22** covered by the light-shielding part **3** are obtained.

In the obtaining (S5) individual lenses, cutting is performed only along the center of the light-shielding part **3** disposed on the upper surface **23a** of the flange part **23** of the lens blank **10**, such that the light-shielding part **3** is cut together with the flange part **23**, to obtain individual lenses **1** each having the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23** are covered by the light-shielding part **3**. The light-shielding part **3** of the lens **1** has a bent-shape in cross-section along the outer lateral surfaces **22a** of the connection part **22** and the upper surfaces **23a** of the flange part **23**. Cutting of the light-shielding part **3** together with the flange part **23** can be carried out by using a known cutting tool **91** such as a blade. It is preferable that a cutting width of the cutting tool **91** is appropriately adjusted such that the flange part **23** of each lens **1** has a length in a range of 200 μm to 1,000 μm .

Method of Manufacturing Light Emitting Device

Next, a method of producing a light emitting device **100** will be described. Although the method of manufacturing the light emitting device **100** is not shown in the drawings,

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the method will be illustrated with reference to FIG. **1** and FIG. **4** that show the structure of the light emitting device **100**.

The method of manufacturing the light emitting device **100** includes providing a lens and disposing the lens with respect to the light emitting element that has been positioned.

The providing the lens is similar to that in the method of manufacturing the lens, such that redundant description thereof will be omitted.

Disposing Lens

In the disposing a lens, a lens **1** is disposed such that light from the light emitting element **51** is transmitted through the lens part **21** of the lens part **21**. In the disposing a lens, the lens **1** is disposed such that the light emitting element **51**, preferably the light emitting element **51** disposed on the substrate **52**, is accommodated in a recess **4** defined by the lens part **21** and the connection part **22**, and located inward of the flange part **23**. The light emitting element **51** may be covered by the light-transmissive member **53**.

In the disposing a lens, the light emitting element **51** is preferably mounted on the substrate **52**, in which the light emitting element **51** is preferably mounted in a flip-chip manner on the substrate **52**. It is preferable that the light emitting element **51** is mounted on the substrate **52** and then the flange part **23** is connected to the substrate **52**. Further, in the disposing a lens, the lens **1** is disposed such that the connection part **22** and the lens part **21** of the lens **1** are spaced apart from the light emitting element **51**. More specifically, the bottom surface in the recess **4** is spaced apart from the uppermost surface which is either the upper surface of the light emitting element **51** or the upper surface of the light-transmissive member **53** in a range of 0.05 mm to 0.5 mm. Further, in the disposing a lens, the connection part **22** (i.e., the recess **4**) is preferably formed such that a distance between the lens part **21** and the light emitting element **51** is smaller than the distance between the connection part **22** and the light emitting element **51**. More specifically, the center of the light emitting element **51** (or a geometrical center of the light emitting element **51**) preferably aligned with the center of the lens part (the Fresnel lens) **21** (or a geometrical center of the lens part (Fresnel lens) **21**), that is, the center of the ridges **21c** arranged in concentric circles or concentric ellipsoids.

Second Embodiment

Next, a second embodiment will be described with reference to FIG. **7**.

FIG. **7** is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to the second embodiment, taken along a line passing through the center of the light emitting element. The same reference numerals may be applied to the components that have been described above and description thereof may be appropriately omitted.

Lens and Light Emitting Device

Lens **1A** and light emitting device **100A** will be described below.

In the lens **1A** and the light emitting device **100A** according to the second embodiment, the light-shielding part **3A** has a large thickness, which is a rectangular shape in a cross-section that is in conformity to the shapes of the outer

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lateral surfaces **22a** of the connection part **22**, which differs from the shape according to the first embodiment, which is a bent shape along the outer lateral surface **22a** of the connection part **22** and the upper surface **23a** of the flange part **23a**. The other parts of the structure are similar to those of the lens **1** and the light emitting device **100** according to the first embodiment.

The lens **1A** and the light emitting device **100A** according to the second embodiment having the light-shielding part **3A** of such a large thickness can yield further reduction of leaking light.

Method of Manufacturing Lens

Next, a method of manufacturing the lens **1A** will be described.

FIG. **8A** is a cross-sectional view schematically illustrating forming a cover blank in a method of manufacturing a lens according to the second embodiment. FIG. **8A** is a cross-sectional view schematically illustrating forming a lens blank in a method of manufacturing a lens according to the second embodiment.

A method of manufacturing the lens **1A** includes, similar to the method of manufacturing the lens according to the first embodiment, forming (S1) a cover blank, removing (S2) a first mold, arranging (S3) the cover blank in a second mold, forming (S4) a lens blank, and obtaining (S5) individual lenses, which are performed in this order.

In the method of manufacturing the lens **1A** which is similar to those described above, except that in the step S3 of arranging the cover blank **20** in the second mold, the cover blank **20** is arranged in a second mold (an upper mold **81** and a lower mold **62**) which is different from the second mold (the upper mold **71** and the lower mold **62**) described above. Also, in the forming (S4) a lens blank **10A**, a thermosetting second resin having a light-absorbance or a light-reflectance higher than that of the first resin is injected in the mold and cured, to obtain a lens blank **10A** with a light-shielding part **3A** disposed between adjacent cover parts **2** and having a rectangular shape in a cross section, which is in conformity to the shapes of the outer lateral surfaces **22a** of the connection part **22**. Further, in the step S5 of obtaining individual lenses **1A**, a center of the light-shielding part **3A** between outer lateral surfaces **22a** of two adjacent connection parts **22** of the lens blank **10A** is cut together with the flange part **23** to obtain individual lenses **1A**, a respective one of which having the outer lateral surfaces **22a** of the connection part **22** and the upper surface **23a** of the flange part **23** covered by the light-shielding part **3**. The light-shielding part **3A** of the lens **1A** thus obtained has a cross-sectional shape of a rectangular shape in conformity to the shape of the outer lateral surfaces **22a** of the connection part **22** and the upper surface of the flange part **23**. Others are similar to those in the method of manufacturing the lens **1**. According to the first embodiment.

Method of Manufacturing Light Emitting Device

Next, a method of manufacturing a light emitting device **100** will be described.

The method of manufacturing the light emitting device **100A** includes providing a lens **1A** and arranging a light emitting element **51**, which are performed in this order. The method of manufacturing the light emitting device **100A** is similar to the method of manufacturing the light emitting device **100** according to the first embodiment.

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Third Embodiment

Next, a third embodiment will be described with reference to FIG. **9**.

FIG. **9** is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to the third embodiment, taken along a line passing through the center of the light emitting device. In the description below, the same reference numerals will be applied to the same or similar structures and description thereof will be appropriately omitted.

Lens and Light Emitting Device

Next, lens **1B** and light emitting device **100B** will be described.

The lens **1B** and the light emitting device **100B** according to a third embodiment differ from the lens **1A** and the light emitting device **100A** according to the second embodiment in which the light-shielding part **3B** has a thickness greater than that of the light-shielding part **3A** of the second embodiment and covers end-surfaces **23b** of the flange **23**. Others are similar to the lens **1A** and the light emitting device **100A** according to the second embodiment.

The lens **1B** and the light emitting device **100B** according to the third embodiment has the light-shielding part **3B** having a greater thickness and covering the outer end-surfaces **23B** as described above, and thus can further reduce light leaking through the light-shielding part **3B**.

Method of Manufacturing Lens

Next, a method of manufacturing a lens **1B** will be described.

FIG. **10** is a flow chart showing a procedure of a method of manufacturing a lens according to the third embodiment. FIG. **11A** is a cross-sectional view schematically illustrating forming a cover blank in the method of manufacturing a lens according to the third embodiment. FIG. **11B** is a cross-sectional view schematically illustrating cutting a cover blank in the method of manufacturing a lens according to the third embodiment. FIG. **11C** is a cross-sectional view schematically illustrating arranging a cut cover blank in a second mold and forming a lens blank in a method of manufacturing a lens according to the third embodiment. FIG. **11D** is a cross-sectional view schematically illustrating cutting a lens blank to obtain individual lenses in a method of manufacturing a lens according to the third embodiment.

The method of manufacturing a lens **1B** includes forming (S11) a cover blank, removing (S12) a first mold, cutting (S13) the cover blank, arranging (S14) the cover blank in a second mold, forming (S15) a lens blank, and obtaining (S16) individual lenses, which are performed in this order, accordingly, a lens **1B** allowing for a reduction of leaking light can be manufactured.

The materials and arrangements of components are similar to those described above for the lens **1B** and therefore redundant description will be appropriately omitted below.

Forming Cover Blank

As shown in FIG. **11A**, in the forming (S11) a cover blank, a thermosetting first resin is injected in a first mold to form a cover blank **20** having a plurality of cover parts **2** each having a lens part **21** having a plurality of lateral surfaces, a connection part **22** connected to the plurality of lateral sides of the lens part and having a plurality of outer lateral

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sides, and a flange part **23** connected to a lower-end portion of the outer lateral sides of the connection part **22**, in which the lens part **21**, the connection part **22**, and the flange part **23** are formed continuous with one another.

In the forming (S11) a cover blank, an upper mold **61** and a lower mold **62** adapted for transfer molding can be used as the first mold. The upper mold **61** and the lower mold **62** are closed, and the first resin, which is heated and softened, is injected under pressure into the first mold through a resin injecting port **61a** formed in the upper mold **61**. The first resin is cured in the heated mold, such that a cover blank **20** having a plurality of cover parts **2** connected one another through the flange part **23** is molded.

In the forming (S11) a cover blank, the upper mold **61** and the lower mold **62** are designed to produce a cover blank **20** having a plurality of cover parts **2** each formed with a recess defined by the lens part **21** and the connection part **22**, and located inward of the flange part **23**. Each of the lens parts **21** of the cover blank **20** has a plurality of ridges **21c** at both upper and lower sides. Further, in the forming (S11) a cover blank, the upper mold **61** and the lower mold **62** are designed to produce a cover blank **20** having a plurality of cover parts **2** each having the flange part **23** with a thickness in a range of 5 μm to 30 μm .

Removing First Mold

In the removing (S12) the first mold, the first mold is removed after the cover blank **20** is formed. In this step, all parts (the upper mold **61** and the lower mold **62**) of the first mold are removed.

Cutting Cover Blank

As shown in FIG. 11B, in the cutting (S13) the cover blank, the cover blank **20** is cut at the flange part **23** between adjacent cover parts **2** to obtain individual cover blanks **20A**. Cutting of the cover blank **20** can be performed by using a cutting tool **91** such as a known blade or the like. It is preferable to adjust the cutting width of the cutting tool **91** such that the flange part **23** of the individual cover blank **20A** has a length in a range of 200 μm to 3,000 μm .

Arranging Cover Blank in Second Mold

In the arranging (S14) the cover blank in the second mold, cut cover blank **20** (singulated cover blank **20A**) is arranged in another upper mold **81A** and a lower mold **82A** adapted for transfer molding.

Forming Lens Blank

In the forming (S15) a lens blank, a thermosetting second resin having a greater light-absorbance or a greater light-reflectance than the first resin is injected in the second mold and cured, to form a lens blank **10B** having a light-shielding part **3** between adjacent cover parts **2**.

In the forming (S15) a lens blank, the upper mold **81A** and the lower mold **82A** are closed, and the second resin, which is heated and softened, is injected under pressure into the second mold through a resin injecting port **81Aa** formed in the upper mold **81A**. The second resin is cured in the heated mold, such that a lens blank **10B** having a light-shielding part **3B** between adjacent cover parts **2**, in a rectangular shape in a cross-section that is in conformity to the shape of

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the outer lateral surface **22a** of the connection part **22** and covering the outer end surfaces **23b** of the flange part **23** is molded.

Obtaining Individual Lenses

As shown in FIG. 11D, in the obtaining (S16) individual lenses, the lens blank **10B** is singulated into individual lenses **1B**. That is, in the obtaining individual lenses: S16, all parts of the second mold are removed to take out the lens blank **10B**, and the lens blank **10B** is cut at a center of the light-shielding part **3B** between adjacent cover parts **2**. The singulating is performed by cutting at the light-shielding part **3B**, thus obtaining individual lenses **1B** each having the light-shielding part **3B** covering the outer lateral surfaces of the connection part **22** and also covering the outer end surfaces **23b** of the flange part **23**.

In the obtaining (S16) individual lenses, the lens blank **10B** is cut at the center of the light-shielding part **3B** between the outer lateral surfaces **22a** of adjacent connection parts **22** and between outer end surfaces **23b** of adjacent flange parts **23**, to obtain individual lenses **1B** each having the light-shielding part **3** covering the outer lateral surfaces **22a** of the connection part **22**, the upper surface **23a** of the flange part **23**, and the outer end surfaces of the flange part **23**. In a cross-section, the light-shielding part **3B** of each of the individual lenses **1B** has a rectangular shape in conformity to the shapes of the outer lateral surfaces **22a** of the connection part **22** and covering the outer end surfaces **23b** of the flange part **23**. Cutting of the light-shielding part **3B** can be performed by using a cutting tool **91** such as a known blade or the like.

Method of Manufacturing Light Emitting Device

Next, a method of manufacturing a light emitting device **100B** will be described.

The method of manufacturing the light emitting device **100B** includes providing a lens and disposing the lens with respect to the light emitting element that has been positioned. The method of manufacturing the light emitting device **100B** can be performed in a similar manner as in the method of manufacturing the light emitting device **100** according to the first embodiment, except for using the lens **1B**.

Fourth Embodiment

As shown in FIG. 12, a plano-convex Fresnel lens having a plurality of ridges **21c** on either outer surface or inner surface (in FIG. 12, the light-incident surface **21a**) may be used in the lens part **21** of the lens **1C** and the light emitting device **100C**.

It is preferable that the lens part **21** has a light incident surface with a plurality of ridges **21c**, and a flat or substantially flat light-emitting surface **21b** such that the light-emitting surface **21b** of the lens part **21** can be arranged in parallel to the light emitting surface of the light emitting element **51**. The light-emitting surface **21b** may have microscopic projections lower than the ridges **21c**, and formed by emboss processing, mat processing, or the like. With this, light emitted from the light-emitting surface **21b** can be uniformly dispersed. FIG. 12 is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a fourth embodiment, where the light emitting device is cut through its center. Also, when a compound eye lens is used, a structure having the plurality

of ridges **21c** either in the outward surface or the inward surface may be employed. As in the lens **1C** and the light emitting device **100C**, employing a structure having a plurality of ridges **21c** only in one surface (in this case the inward surface) of the lens part **21** allows for a reduction in a dimension in height direction, because the outward surface does not have the plurality of ridges **21c**.

Fifth Embodiment

As shown in FIG. **13**, a lens **1D** may have a structure in which a connection part **22** is connected to the lateral sides of the lens part **21** and extended outward with respect to the lateral sides of the lens part **21**, and a flange part **23** is connected to lower end part of the connection part **22**. A light emitting device **100D** according to the fifth embodiment may have a structure in which the lens **1D** and a substrate **52** having a light emitting element **51** mounted thereon are bonded through an interposing member **54** which is formed of a light-reflecting material and disposed on the substrate **52**. FIG. **13** is a cross-sectional view schematically showing a structure of a light emitting device that includes a lens according to a fifth embodiment, where the light emitting device is cut through its center.

In the lens **1D**, outer lateral sides of the connection part **22** and upper surfaces of the flange part **23** are covered by a light-shielding part **3**. In the lens **1D** and the light emitting device **100D**, a recess **4a** is defined by the lens part **21**, a portion of the connection part **22**, and the interposing member **54**.

In the case of the lens **1D**, the lower surface of the flange part **23** is bonded to the substrate through the interposing member **54** such that the lens part **21** is located facing the light emitting element **51** mounted on the substrate **52**.

In the light emitting device **100D**, the height of the interposing layer **54** is determined such that the light emitting element **51** mounted on the substrate **52** is spaced apart from the lens part **21** of the lens **1D**.

In the lens **1D** and the light emitting device **100D**, the outer lateral surfaces of the flange part **23** and the outer lateral surfaces of the interposing member **54** may also be covered by the light-shielding part **3**.

Obviously, numerous modifications and variations of the present invention are possible in light of the above teachings. It is therefore to be understood that within the scope of the appended claims, the invention may be practiced otherwise than as specifically described herein.

What is claimed is:

1. A method of manufacturing a lens, the method comprising:

forming a cover blank, the forming a cover blank comprising, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, the lens part and the connection part defining a recess opening downward, the lens part defining a bottom surface of the recess and the connection part defining lateral surfaces of the recess and surrounding the opening of the recess, the flange part extending outward from a periphery of the recess, and, the lens part, the flange part, and the connection part being continuous to one another;

removing a part or all parts of the first mold;
arranging the cover blank in a second mold;

forming a lens blank, the forming a lens blank comprising, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold, and curing the second resin, to form a lens blank having a light-shielding part between adjacent cover parts; and obtaining individual lenses, the obtaining individual lenses comprising, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part.

2. A method of manufacturing a light emitting device, the method comprising:

providing a lens using a method according to claim **1**, and disposing the lens at a location that allows light from the light emitting element to be transmitted through the lens part of the lens.

3. The method of manufacturing a light emitting device according to claim **2**, wherein the disposing the lens comprises, mounting a light emitting element on a substrate, and bonding the flange part to the substrate.

4. The method of manufacturing a light emitting device according to claim **2**, wherein, in the disposing the lens, the lens is disposed such that the connection part and the lens part are spaced apart from the light emitting element.

5. The method of manufacturing a light emitting device according to claim **4**, wherein, in the disposing the lens, the lens is arranged such that a distance between the lens part and the light emitting element is smaller than a distance between the connection part and the light emitting element.

6. A method of manufacturing a lens, the method comprising:

forming a cover blank, the forming a cover blank comprising, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection part connected to an outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, and, the lens part, the flange part, and the connection part being continuous to one another, with a thickness of the flange part in a range of 5 μm to 30 μm ;

removing a part or all parts of the first mold;

arranging the cover blank in a second mold;

forming a lens blank, the forming a lens blank comprising, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold and curing the second resin, to form a lens blank having a light-shielding part between adjacent cover parts; and

obtaining individual lenses, the obtaining individual lenses comprising, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part.

7. A method of manufacturing a lens, the method comprising:

forming a cover blank, the forming a cover blank comprising, injecting a thermosetting first resin in a first mold and curing the first resin, to form a cover blank having a plurality of cover parts, each of the cover parts including a lens part, a connection part connected to an

outer periphery of the lens part, and a flange part connected to a lower-end portion of an outer periphery of the connection part, and, the lens part, the flange part, and the connection part being continuous to one another;

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removing the first mold;

cutting the cover blank at the flange part located between adjacent cover parts;

arranging the cut cover blank in a second mold;

forming a lens blank, the forming a lens blank comprising, injecting a thermosetting second resin having a greater light absorptance or a greater light reflectance than the first resin into the second mold and curing the second resin to form a lens blank having a light-shielding part between adjacent cover parts; and

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obtaining individual lenses, the obtaining individual lenses comprising, taking out the lens blank from the second mold, and cutting the lens blank at the light-shielding part located between the adjacent cover parts to obtain individual lenses each having an outer lateral side of the connection part covered by the light-shielding part and an outer end surface of the flange part covered by the light-shielding part.

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8. The method of manufacturing a lens according to claim 7, wherein, in the forming a cover blank, a recess is defined by the lens part and the connection part, and the flange part extends outward from a periphery of the recess.

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9. The method of manufacturing a lens according to claim 7, wherein, in the forming a cover blank, the flange part is formed with a thickness in a range of 5 μm to 30 μm .

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